Work Order ID 92464

October-30-12 8:48:27 AM

92464

Item ID: D350-636-011

Accept *N900040100*

Setup Start *NS1*

Stop *NS2*

Revision ID:

Item Name: Skidtube LH

Start Date: 30/10/2012 **Start Qty:** 1.00 *1*

Required Date: 13/11/2012 **Req'd Qty:** 1.00 *1*

Cust Item ID:

Customer:

Reference:

Run Start *NR1*

Stop *NR2*

Approvals: **Process Plan:** MLS **Date:** 12-10-30 **Tooling:** **Date:**

QC: **Date:** **SPC (Y/N):** **Date:**

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp

Draw Nbr	Revision Nbr
D2750	F

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
100 *100* DC Document Control	DOCUMENT CONTROL	0.00 / 0.00	SL						DAS 15 12 11 26

Memo

Photocopy blue file and type labels per PPP D350-636-011 CHG 006

[signature] for MLS 12-11-23

DQA: ________ Date: ____________

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date:

Work Order: ____________ Part No. ____________ NCR No. ____________	**DISPOSITION** Rework ☐ Scrap ☐ Use-as-is ☐ Work Order Update ☐	**AGAINST DEPARTMENT/PROCESS** Skid-tube ☐ Crosstube ☐ Water Jet ☐ Engineering ☐ Machining ☐ Small Fab ☐ Prod. Eng. Coor. ☐ Quality ☐ Thermoforming ☐ Finishing ☐ Rec/Store/Packaging ☐ Other ☐ Large Fab ☐ Composite ☐ Supplier ☐ ☐

Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data ☐									
Equip/Tooling ☐									
Operator ☐									
Material ☐									
Setup ☐									
Other ☐									
Process ☐									
Supplier ☐									
Training ☐									
Unapproved ☐									

FAULT CATEGORY

Landing Gear	**General**			
☐ Bending	☐ Bend	☐ Grain	☐ Ovalized	☐ Pressure/Forced
☐ Centre Not Concentric to O/S	☐ BOM/Route	☐ Hardware	☐ Over/Under tolerance	☐ Temperature/Cure
☐ Cracks	☐ Broken/Damaged	☐ Inspection Incomplete	☐ Part Incorrect	☐ Weld
☐ Crushed/Crimped	☐ Burrs	☐ Instructions Incomplete/Unclear	☐ Part Lost/Missing	☐ Wrong Stock Pulled
☐ Cuffs	☐ Contamination	☐ Maintenance	☐ Part Moved	
☐ Heat Treat	☐ Countersink	☐ Mislabeled	☐ Positioned Wrong	
☐ Inspection Strip in Tube	☐ Cut Too Short	☐ Misread	☐ Power Loss/Surge	☐ Other
☐ Ripples in Bend	☐ Drill Holes	☐ Offset		
☐ Torque Waves in Extrusion	☐ Drawing	☐ Out of Calibration		
☐ Turning Sequence	☐ Finish	☐ Out of Sequence		
☐ Wave/Twist in Tube	☐ Folio	☐ Outside Dimensions		

Work Order ID 92464

October-30-12 8:48:27 AM

92464

Item ID: D350-636-011

Revision ID:

Item Name: Skidtube LH

Accept *N900040100*

Setup Start *NS1*

Stop *NS2*

Start Date: 30/10/2012 **Start Qty:** 1.00 *1*

Required Date: 13/11/2012 **Req'd Qty:** 1.00 *1*

Cust Item ID:

Customer:

Reference:

Approvals: **Process Plan:** ________ **Date:** ________ **Tooling:** ________ **Date:** ________

QC: ________ **Date:** ________ **SPC (Y/N):** ________ **Date:** ________

Run Start *NR1*

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
110		0.00							
110 Skidtubes	Skidtubes								
Skidtubes	Memo	0.00							

1- Pick D2600-3 Bent

2- Deburr FWD and AFT ends, remove bending marks. Scribe batch# inside AFT end per dwg D2750

3- Drill pilot holes for blade fitting bolt holes using DT8983. Open to 0.500", deburr.

4- Locate DT8330 off of blade fitting bolt holes and drill pilot holes for blade fitting

5- Drill only two fwd step holes using DT9616. Ensure proper positioning.

6- Drill pilot holes as per Dwg D2750 sheet 4 (D2750-1 details).Drill using drill Jig DT8150 & DT8863A for first side only DT8863B for second side (detail B)

7- Clecko DT8863B on second side of tube and drill pilot holes for detail B. ***SECOND SIDE***

8-Open up holes for Detail B to 0.375" (4 holes per side)and blade fitting location holes to 0.500" (total of 4 holes per side) as per dwg D2750 .Open up holes for ground handling and detail C to 0.500" (8 holes per side)

9-Drill pilot holes for wearplates as per Dwg D2750 using DT8108 open to 0.297".

10-Open up holes of Detail A to 0.297" (total of 2 holes per side)

PB 12/10/31

DQA: ________ Date: ____________

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date:

Work Order: ______ Part No. ______ NCR No. ______	**DISPOSITION**	**AGAINST DEPARTMENT/PROCESS**
	Rework ☐ Scrap ☐ Use-as-is ☐ Work Order Update ☐	Skid-tube ☐ Crosstube ☐ Water Jet ☐ Engineering ☐ Machining ☐ Small Fab ☐ Prod. Eng. Coor. ☐ Quality ☐ Thermoforming ☐ Finishing ☐ Rec/Store/Packaging ☐ Other ☐ Large Fab ☐ Composite ☐ Supplier ☐ ☐

Root Cause		Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data	☐									
Equip/Tooling	☐									
Operator	☐									
Material	☐									
Setup	☐									
Other	☐									
Process	☐									
Supplier	☐									
Training	☐									
Unapproved	☐									

FAULT CATEGORY

Landing Gear	**General**			
☐ Bending	☐ Bend	☐ Grain	☐ Ovalized	☐ Pressure/Forced
☐ Centre Not Concentric to O/S	☐ BOM/Route	☐ Hardware	☐ Over/Under tolerance	☐ Temperature/Cure
☐ Cracks	☐ Broken/Damaged	☐ Inspection Incomplete	☐ Part Incorrect	☐ Weld
☐ Crushed/Crimped	☐ Burrs	☐ Instructions Incomplete/Unclear	☐ Part Lost/Missing	☐ Wrong Stock Pulled
☐ Cuffs	☐ Contamination	☐ Maintenance	☐ Part Moved	
☐ Heat Treat	☐ Countersink	☐ Mislabeled	☐ Positioned Wrong	
☐ Inspection Strip in Tube	☐ Cut Too Short	☐ Misread	☐ Power Loss/Surge	☐ Other ______
☐ Ripples in Bend	☐ Drill Holes	☐ Offset	______	
☐ Torque Waves in Extrusion	☐ Drawing	☐ Out of Calibration	______	
☐ Turning Sequence	☐ Finish	☐ Out of Sequence	______	
☐ Wave/Twist in Tube	☐ Folio	☐ Outside Dimensions		

Work Order ID 92464

October-30-12 8:48:27 AM

92464

Item ID: D350-636-011

Accept *N900040100*

Setup **Start** *NS1*

Stop *NS2*

Revision ID:

Item Name: Skidtube LH

Start Date: 30/10/2012 **Start Qty:** 1.00 *1*

Required Date: 13/11/2012 **Req'd Qty:** 1.00 *1*

Cust Item ID:

Customer:

Reference:

Run **Start** *NR1*

Stop *NR2*

Approvals: **Process Plan:** ______ **Date:** ______ **Tooling:** ______ **Date:** ______

QC: ______ **Date:** ______ **SPC (Y/N):** ______ **Date:** ______

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
	11-Weld D2744 Cap as per Dwg D2750 and QSI 004.Fill grooves in bend left from bending as per QSI 004 A/R Aluminum Rod batch: M122357 BE 12-10-31								
	12-Grind welds flush as per Dwg D2750 B 12/11/01								
120 *120* QC Quality Control	QC10- Inspect visual per QSI004- ground welds **Memo**	0.00 0.00	DAS 16 12\11\02						
130 *130* QC Quality Control	QC5- Inspect part completeness to step on W/O **Memo**	0.00 0.00	DAS 16 12\11\02						

DQA: ________ Date: ____________

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date:

Work Order: ______	DISPOSITION	AGAINST DEPARTMENT/PROCESS			
Part No. ______	Rework ☐	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐
NCR No. ______	Scrap ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coor. ☐	Quality ☐
	Use-as-is ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐
	Work Order Update ☐	Large Fab ☐	Composite ☐	Supplier ☐	☐

Root Cause		Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data	☐									
Equip/Tooling	☐									
Operator	☐									
Material	☐									
Setup	☐									
Other	☐									
Process	☐									
Supplier	☐									
Training	☐									
Unapproved	☐									

FAULT CATEGORY

Landing Gear	General			
☐ Bending	☐ Bend	☐ Grain	☐ Ovalized	☐ Pressure/Forced
☐ Centre Not Concentric to O/S	☐ BOM/Route	☐ Hardware	☐ Over/Under tolerance	☐ Temperature/Cure
☐ Cracks	☐ Broken/Damaged	☐ Inspection Incomplete	☐ Part Incorrect	☐ Weld
☐ Crushed/Crimped	☐ Burrs	☐ Instructions Incomplete/Unclear	☐ Part Lost/Missing	☐ Wrong Stock Pulled
☐ Cuffs	☐ Contamination	☐ Maintenance	☐ Part Moved	
☐ Heat Treat	☐ Countersink	☐ Mislabeled	☐ Positioned Wrong	
☐ Inspection Strip in Tube	☐ Cut Too Short	☐ Misread	☐ Power Loss/Surge	☐ Other ______
☐ Ripples in Bend	☐ Drill Holes	☐ Offset	______	
☐ Torque Waves in Extrusion	☐ Drawing	☐ Out of Calibration	______	
☐ Turning Sequence	☐ Finish	☐ Out of Sequence	______	
☐ Wave/Twist in Tube	☐ Folio	☐ Outside Dimensions		

Work Order ID 92464

October-30-12 8:48:27 AM

92464

Item ID: D350-636-011
Revision ID:
Item Name: Skidtube LH

Accept *N900040100*

Setup **Start** *NS1*
Stop *NS2*

Start Date: 30/10/2012 **Start Qty:** 1.00 *1*
Required Date: 13/11/2012 **Req'd Qty:** 1.00 *1*
Reference:

Cust Item ID:
Customer:

Run **Start** *NR1*
Stop *NR2*

Approvals: **Process Plan:** ______ **Date:** ______ **Tooling:** ______ **Date:** ______
QC: ______ **Date:** ______ **SPC (Y/N):** ______ **Date:** ______

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
140 *140* HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 **Memo**	0.00 0.00				1	0		CF 12-11-6
150 *150* QC Quality Control	QC7-Inspect Chemical Conversion Coat **Memo**	0.00 0.00					0		SAD 12-11-6

DQA: ________ Date: ________________

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date:

	DISPOSITION	AGAINST DEPARTMENT/PROCESS
Work Order: ____________	Rework ☐	Skid-tube ☐ Crosstube ☐ Water Jet ☐ Engineering ☐
Part No. ____________	Scrap ☐	Machining ☐ Small Fab ☐ Prod. Eng. Coor. ☐ Quality ☐
NCR No. ____________	Use-as-is ☐	Thermoforming ☐ Finishing ☐ Rec/Store/Packaging ☐ Other ☐
	Work Order Update ☐	Large Fab ☐ Composite ☐ Supplier ☐ ☐

Root Cause		Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data	☐									
Equip/Tooling	☐									
Operator	☐									
Material	☐									
Setup	☐									
Other	☐									
Process	☐									
Supplier	☐									
Training	☐									
Unapproved	☐									

FAULT CATEGORY

Landing Gear

- ☐ Bending
- ☐ Centre Not Concentric to O/S
- ☐ Cracks
- ☐ Crushed/Crimped
- ☐ Cuffs
- ☐ Heat Treat
- ☐ Inspection Strip in Tube
- ☐ Ripples in Bend
- ☐ Torque Waves in Extrusion
- ☐ Turning Sequence
- ☐ Wave/Twist in Tube

General

- ☐ Bend
- ☐ BOM/Route
- ☐ Broken/Damaged
- ☐ Burrs
- ☐ Contamination
- ☐ Countersink
- ☐ Cut Too Short
- ☐ Drill Holes
- ☐ Drawing
- ☐ Finish
- ☐ Folio
- ☐ Grain
- ☐ Hardware
- ☐ Inspection Incomplete
- ☐ Instructions Incomplete/Unclear
- ☐ Maintenance
- ☐ Mislabeled
- ☐ Misread
- ☐ Offset
- ☐ Out of Calibration
- ☐ Out of Sequence
- ☐ Outside Dimensions
- ☐ Ovalized
- ☐ Over/Under tolerance
- ☐ Part Incorrect
- ☐ Part Lost/Missing
- ☐ Part Moved
- ☐ Positioned Wrong
- ☐ Power Loss/Surge
- ☐ Pressure/Forced
- ☐ Temperature/Cure
- ☐ Weld
- ☐ Wrong Stock Pulled
- ☐ Other ____________________

Work Order ID 92464

October-30-12 8:48:27 AM

92464

Item ID: D350-636-011

Revision ID:

Item Name: Skidtube LH

Accept *N900040100*

Setup **Start** *NS1*

Stop *NS2*

Start Date: 30/10/2012 **Start Qty:** 1.00 *1*

Required Date: 13/11/2012 **Req'd Qty:** 1.00 *1*

Reference:

Cust Item ID:

Customer:

Approvals: **Process Plan:** ____ **Date:** ____ **Tooling:** ____ **Date:** ____

QC: ____ **Date:** ____ **SPC (Y/N):** ____ **Date:** ____

Run **Start** *NR1*

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160		0.00							
160 Skidtubes Skidtubes	Skidtubes								
	Memo	0.00							

1-Open up holes of Detail C and ground handling to 0.625" (total of 8 holes per side) as per dwg D2750.

2-Open up holes of Detail B to 0.750" (total of 4 holes per side) as per dwg D2750.

3- Open float hole to 0.500" (4 per side)

4-Chamfer holes of Detail B, C, ground handling and float holes per dwg D2750 (welding instructions on sheet 8)

5-Deburr and blow out all chips from inside of tube

6- Prepare tube for welding, remove alodine as required.

DP 12-11-7

7-Bond web D2739 in place as per QSI 015
A/R Sikaflex-291 batch: 123025
exp. date: 13-6-22 - DC 12/11/07

8- Weld spacers D3490-1, D3490-3 and D2743 as per dwg D2750 & QSI004 (welding instructions on sheet 8)
A/R Aluminum Rod batch: M122357

9- At section AJ-AJ drill out x-bolt spacer to 0.404"

BB 12-11-08

10-Grind welds flush as per Dwg D2750

BB 12/11/09

DQA: ________ Date: ____________

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date:

Work Order: ____________________

Part No. ____________________

NCR No. ____________________

DISPOSITION

- Rework ☐
- Scrap ☐
- Use-as-is ☐
- Work Order Update ☐

AGAINST DEPARTMENT/PROCESS

- Skid-tube ☐
- Machining ☐
- Thermoforming ☐
- Large Fab ☐
- Crosstube ☐
- Small Fab ☐
- Finishing ☐
- Composite ☐
- Water Jet ☐
- Prod. Eng. Coor. ☐
- Rec/Store/Packaging ☐
- Supplier ☐
- Engineering ☐
- Quality ☐
- Other ☐
- ☐

Root Cause		Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data	☐									
Equip/Tooling	☐									
Operator	☐									
Material	☐									
Setup	☐									
Other	☐									
Process	☐									
Supplier	☐									
Training	☐									
Unapproved	☐									

FAULT CATEGORY

Landing Gear

- ☐ Bending
- ☐ Centre Not Concentric to O/S
- ☐ Cracks
- ☐ Crushed/Crimped
- ☐ Cuffs
- ☐ Heat Treat
- ☐ Inspection Strip in Tube
- ☐ Ripples in Bend
- ☐ Torque Waves in Extrusion
- ☐ Turning Sequence
- ☐ Wave/Twist in Tube

General

- ☐ Bend
- ☐ BOM/Route
- ☐ Broken/Damaged
- ☐ Burrs
- ☐ Contamination
- ☐ Countersink
- ☐ Cut Too Short
- ☐ Drill Holes
- ☐ Drawing
- ☐ Finish
- ☐ Folio
- ☐ Grain
- ☐ Hardware
- ☐ Inspection Incomplete
- ☐ Instructions Incomplete/Unclear
- ☐ Maintenance
- ☐ Mislabeled
- ☐ Misread
- ☐ Offset
- ☐ Out of Calibration
- ☐ Out of Sequence
- ☐ Outside Dimensions
- ☐ Ovalized
- ☐ Over/Under tolerance
- ☐ Part Incorrect
- ☐ Part Lost/Missing
- ☐ Part Moved
- ☐ Positioned Wrong
- ☐ Power Loss/Surge
- ☐ Pressure/Forced
- ☐ Temperature/Cure
- ☐ Weld
- ☐ Wrong Stock Pulled
- ☐ Other ____________

Work Order ID 92464

October-30-12 8:48:27 AM

92464

Item ID: D350-636-011 **Accept** *N900040100* **Setup Start** *NS1*

Revision ID:

Item Name: Skidtube LH **Stop** *NS2*

Start Date: 30/10/2012 **Start Qty:** 1.00 *1* **Cust Item ID:**

Required Date: 13/11/2012 **Req'd Qty:** 1.00 *1* **Customer:**

Reference:

Approvals: **Process Plan:** ______ **Date:** ______ **Tooling:** ______ **Date:** ______ **Run Start** *NR1*

QC: ______ **Date:** ______ **SPC (Y/N):** ______ **Date:** ______ **Stop** *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
	11-Spot face ground handling holes section (total of 4 places per side) as per dwg D2750				B 12/11/09				
	12-Deburr holes								
170 *170* QC Quality Control	QC10- Inspect visual per QSI004- ground welds	0.00				12-11-12			DAS 09
	Memo	0.00							
180 *180* QC Quality Control	QC5- Inspect part completeness to step on W/O	0.00				12-11-12			DAS 09
	Memo ***VERIFY C'BOARD IS GOOD***	0.00							

DQA: ________ Date: ____________

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date:

	DISPOSITION	AGAINST DEPARTMENT/PROCESS			
Work Order: ____________	Rework ☐	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐
Part No. ____________	Scrap ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coor. ☐	Quality ☐
NCR No. ____________	Use-as-is ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐
	Work Order Update ☐	Large Fab ☐	Composite ☐	Supplier ☐	☐

Root Cause		Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data	☐									
Equip/Tooling	☐									
Operator	☐									
Material	☐									
Setup	☐									
Other	☐									
Process	☐									
Supplier	☐									
Training	☐									
Unapproved	☐									

FAULT CATEGORY

Landing Gear	General			
☐ Bending	☐ Bend	☐ Grain	☐ Ovalized	☐ Pressure/Forced
☐ Centre Not Concentric to O/S	☐ BOM/Route	☐ Hardware	☐ Over/Under tolerance	☐ Temperature/Cure
☐ Cracks	☐ Broken/Damaged	☐ Inspection Incomplete	☐ Part Incorrect	☐ Weld
☐ Crushed/Crimped	☐ Burrs	☐ Instructions Incomplete/Unclear	☐ Part Lost/Missing	☐ Wrong Stock Pulled
☐ Cuffs	☐ Contamination	☐ Maintenance	☐ Part Moved	
☐ Heat Treat	☐ Countersink	☐ Mislabeled	☐ Positioned Wrong	
☐ Inspection Strip in Tube	☐ Cut Too Short	☐ Misread	☐ Power Loss/Surge	☐ Other ____________
☐ Ripples in Bend	☐ Drill Holes	☐ Offset	____________	
☐ Torque Waves in Extrusion	☐ Drawing	☐ Out of Calibration	____________	
☐ Turning Sequence	☐ Finish	☐ Out of Sequence	____________	
☐ Wave/Twist in Tube	☐ Folio	☐ Outside Dimensions		

Work Order ID 92464

92464

October-30-12 8:48:27 AM

Item ID:	D350-636-011	**Accept**	*N900040100*	**Setup Start**	*NS1*
Revision ID:				**Stop**	*NS2*
Item Name:	Skidtube LH				
Start Date:	30/10/2012	**Start Qty:** 1.00	*1*	**Cust Item ID:**	
Required Date:	13/11/2012	**Req'd Qty:** 1.00	*1*	**Customer:**	
Reference:					

Approvals:	**Process Plan:**	**Date:**	**Tooling:**	**Date:**	**Run Start**	*NR1*
	QC:	**Date:**	**SPC (Y/N):**	**Date:**	**Stop**	*NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190 *190* HandFinish Hand Finishing	Pressure Wash per QSI005 4.3	0.00				1			KB 12-11-13
	Memo Re-alodine tube as per QSI 005 section 4.1.2.1 do not acid etch.	0.00							
200 *200* Powdercoat Powder Coating	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum	0.00				1	X	Ø	MJ 12/11/13
M122878	**Memo** START TIME: 3:40 OVEN TEMPERATURE: 320°F FINISH TIME: 4:10	0.00							
210 *210* QC Quality Control	QC3- Inspect Part Finish	0.00				1 LH	Ø	GL	12/11/13
	Memo Inspect for foreign object per QSI 024	0.00							

DQA: ________ Date: ____________

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date:

Work Order: ____________	DISPOSITION	AGAINST DEPARTMENT/PROCESS
Part No. ____________	Rework ☐	Skid-tube ☐ Crosstube ☐ Water Jet ☐ Engineering ☐
NCR No. ____________	Scrap ☐	Machining ☐ Small Fab ☐ Prod. Eng. Coor. ☐ Quality ☐
	Use-as-is ☐	Thermoforming ☐ Finishing ☐ Rec/Store/Packaging ☐ Other ☐
	Work Order Update ☐	Large Fab ☐ Composite ☐ Supplier ☐ ☐

Root Cause		Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data	☐									
Equip/Tooling	☐									
Operator	☐									
Material	☐									
Setup	☐									
Other	☐									
Process	☐									
Supplier	☐									
Training	☐									
Unapproved	☐									

FAULT CATEGORY

Landing Gear	General			
☐ Bending	☐ Bend	☐ Grain	☐ Ovalized	☐ Pressure/Forced
☐ Centre Not Concentric to O/S	☐ BOM/Route	☐ Hardware	☐ Over/Under tolerance	☐ Temperature/Cure
☐ Cracks	☐ Broken/Damaged	☐ Inspection Incomplete	☐ Part Incorrect	☐ Weld
☐ Crushed/Crimped	☐ Burrs	☐ Instructions Incomplete/Unclear	☐ Part Lost/Missing	☐ Wrong Stock Pulled
☐ Cuffs	☐ Contamination	☐ Maintenance	☐ Part Moved	
☐ Heat Treat	☐ Countersink	☐ Mislabeled	☐ Positioned Wrong	
☐ Inspection Strip in Tube	☐ Cut Too Short	☐ Misread	☐ Power Loss/Surge	☐ Other ____________
☐ Ripples in Bend	☐ Drill Holes	☐ Offset		____________
☐ Torque Waves in Extrusion	☐ Drawing	☐ Out of Calibration		____________
☐ Turning Sequence	☐ Finish	☐ Out of Sequence		____________
☐ Wave/Twist in Tube	☐ Folio	☐ Outside Dimensions		

Work Order ID 92464

October-30-12 8:48:27 AM

92464

Item ID: D350-636-011

Revision ID:

Item Name: Skidtube LH

Accept *N900040100*

Setup Start *NS1*

Stop *NS2*

Start Date: 30/10/2012 **Start Qty:** 1.00 *1*

Required Date: 13/11/2012 **Req'd Qty:** 1.00 *1*

Cust Item ID:

Customer:

Reference:

Run Start *NR1*

Stop *NR2*

Approvals: **Process Plan:** ______ **Date:** ______ **Tooling:** ______ **Date:** ______

QC: ______ **Date:** ______ **SPC (Y/N):** ______ **Date:** ______

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
220 *220* HandFinish Hand Finishing	HandFinishing **Memo** 1- Install inserts as per Dwg D2750	0.00 0.00				1kH	∅	Sd	11/11/19
230 *230* HandFinish Hand Finishing	HandFinishing **Memo** 1-Inspect for Foreign Objects 2-Spray inside of tube with "LPS-3" batch: N/A 3-Install blade fitting D3488-041, wearshoes and ground handling hardware as per dwg D2750 SIKA FLEX 241 BATCH: M123025 EXP DATE: 13/03 4-assemble o'ring to plug as per dwg D3492 and apply o'ring lube A/R 55-o'ring lube batch: M121651 5-Coat all exposed fasteners with "LPS Procyon" batch: M114596	0.00 0.00				1kH	∅	Sd	11/11/19

DQA: ________ Date: ____________

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date:

Work Order: ______ Part No. ______ NCR No. ______	**DISPOSITION** Rework ☐ Scrap ☐ Use-as-is ☐ Work Order Update ☐	**AGAINST DEPARTMENT/PROCESS** Skid-tube ☐ Crosstube ☐ Water Jet ☐ Engineering ☐ Machining ☐ Small Fab ☐ Prod. Eng. Coor. ☐ Quality ☐ Thermoforming ☐ Finishing ☐ Rec/Store/Packaging ☐ Other ☐ Large Fab ☐ Composite ☐ Supplier ☐ ☐

Root Cause		Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data	☐									
Equip/Tooling	☐									
Operator	☐									
Material	☐									
Setup	☐									
Other	☐									
Process	☐									
Supplier	☐									
Training	☐									
Unapproved	☐									

FAULT CATEGORY

Landing Gear	General			
☐ Bending	☐ Bend	☐ Grain	☐ Ovalized	☐ Pressure/Forced
☐ Centre Not Concentric to O/S	☐ BOM/Route	☐ Hardware	☐ Over/Under tolerance	☐ Temperature/Cure
☐ Cracks	☐ Broken/Damaged	☐ Inspection Incomplete	☐ Part Incorrect	☐ Weld
☐ Crushed/Crimped	☐ Burrs	☐ Instructions Incomplete/Unclear	☐ Part Lost/Missing	☐ Wrong Stock Pulled
☐ Cuffs	☐ Contamination	☐ Maintenance	☐ Part Moved	
☐ Heat Treat	☐ Countersink	☐ Mislabeled	☐ Positioned Wrong	
☐ Inspection Strip in Tube	☐ Cut Too Short	☐ Misread	☐ Power Loss/Surge	☐ Other ______
☐ Ripples in Bend	☐ Drill Holes	☐ Offset	______	
☐ Torque Waves in Extrusion	☐ Drawing	☐ Out of Calibration	______	
☐ Turning Sequence	☐ Finish	☐ Out of Sequence	______	
☐ Wave/Twist in Tube	☐ Folio	☐ Outside Dimensions		

Work Order ID 92464

October-30-12 8:48:27 AM

92464

Item ID:	D350-636-011	**Accept**	*N900040100*
Revision ID:		**Setup Start**	*NS1*
Item Name:	Skidtube LH	**Stop**	*NS2*
Start Date:	30/10/2012	**Start Qty:** 1.00 *1*	**Cust Item ID:**
Required Date:	13/11/2012	**Req'd Qty:** 1.00 *1*	**Customer:**
Reference:			

Approvals: **Process Plan:** ______ **Date:** ______ **Tooling:** ______ **Date:** ______ **Run Start** *NR1*

QC: ______ **Date:** ______ **SPC (Y/N):** ______ **Date:** ______ **Stop** *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
240 *240* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00 JAS 15 9-89 12 11 12				1			
250 *250* Packaging Packaging	Pick Kit Memo	0.00 0.00				1			12/11/23 JD
260 *260* QC Quality Control	QC4- 100% Inspect kits for completeness Memo ******ensure antiseize is on AN8C21A bolts*******	0.00 0.00 JAS 15 9-89 12 11.26				1			

DQA: ________ Date: ____________

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date:

	DISPOSITION	AGAINST DEPARTMENT/PROCESS			
Work Order: ______________	Rework ☐	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐
Part No. ______________	Scrap ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coor. ☐	Quality ☐
	Use-as-is ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐
NCR No. ______________	Work Order Update ☐	Large Fab ☐	Composite ☐	Supplier ☐	☐

Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data ☐									
Equip/Tooling ☐									
Operator ☐									
Material ☐									
Setup ☐									
Other ☐									
Process ☐									
Supplier ☐									
Training ☐									
Unapproved ☐									

FAULT CATEGORY

Landing Gear	General			
☐ Bending	☐ Bend	☐ Grain	☐ Ovalized	☐ Pressure/Forced
☐ Centre Not Concentric to O/S	☐ BOM/Route	☐ Hardware	☐ Over/Under tolerance	☐ Temperature/Cure
☐ Cracks	☐ Broken/Damaged	☐ Inspection Incomplete	☐ Part Incorrect	☐ Weld
☐ Crushed/Crimped	☐ Burrs	☐ Instructions Incomplete/Unclear	☐ Part Lost/Missing	☐ Wrong Stock Pulled
☐ Cuffs	☐ Contamination	☐ Maintenance	☐ Part Moved	
☐ Heat Treat	☐ Countersink	☐ Mislabeled	☐ Positioned Wrong	
☐ Inspection Strip in Tube	☐ Cut Too Short	☐ Misread	☐ Power Loss/Surge	☐ Other
☐ Ripples in Bend	☐ Drill Holes	☐ Offset	____________	
☐ Torque Waves in Extrusion	☐ Drawing	☐ Out of Calibration	____________	
☐ Turning Sequence	☐ Finish	☐ Out of Sequence	____________	
☐ Wave/Twist in Tube	☐ Folio	☐ Outside Dimensions		

Work Order ID 92464

October-30-12 8:48:27 AM

92464

Item ID: D350-636-011

Revision ID:

Item Name: Skidtube LH

Accept *N900040100*

Setup Start *NS1*

Stop *NS2*

Start Date: 30/10/2012 **Start Qty:** 1.00 *1*

Required Date: 13/11/2012 **Req'd Qty:** 1.00 *1*

Cust Item ID:

Customer:

Reference:

Run Start *NR1*

Stop *NR2*

Approvals: **Process Plan:** ______ **Date:** ______ **Tooling:** ______ **Date:** ______

QC: ______ **Date:** ______ **SPC (Y/N):** ______ **Date:** ______

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
270 *270* Packaging Packaging	Packaging **Memo** Package as per PPP D350-636-011	0.00 0.00	Rec I Loc 072		1		12/11/26		DAS 20
280 *280* QC Quality Control	QC21- Final Inspection - Work Order Release **Memo**	0.00 0.00						12/11/27	

MF 12-11-26

DQA: ________ Date: ____________

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date:

	DISPOSITION	AGAINST DEPARTMENT/PROCESS			
Work Order: ____________	Rework ☐	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐
Part No. ____________	Scrap ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coor. ☐	Quality ☐
NCR No. ____________	Use-as-is ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐
	Work Order Update ☐	Large Fab ☐	Composite ☐	Supplier ☐	☐

Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data ☐									
Equip/Tooling ☐									
Operator ☐									
Material ☐									
Setup ☐									
Other ☐									
Process ☐									
Supplier ☐									
Training ☐									
Unapproved ☐									

FAULT CATEGORY

Landing Gear	General			
☐ Bending	☐ Bend	☐ Grain	☐ Ovalized	☐ Pressure/Forced
☐ Centre Not Concentric to O/S	☐ BOM/Route	☐ Hardware	☐ Over/Under tolerance	☐ Temperature/Cure
☐ Cracks	☐ Broken/Damaged	☐ Inspection Incomplete	☐ Part Incorrect	☐ Weld
☐ Crushed/Crimped	☐ Burrs	☐ Instructions Incomplete/Unclear	☐ Part Lost/Missing	☐ Wrong Stock Pulled
☐ Cuffs	☐ Contamination	☐ Maintenance	☐ Part Moved	
☐ Heat Treat	☐ Countersink	☐ Mislabeled	☐ Positioned Wrong	
☐ Inspection Strip in Tube	☐ Cut Too Short	☐ Misread	☐ Power Loss/Surge	☐ Other
☐ Ripples in Bend	☐ Drill Holes	☐ Offset		
☐ Torque Waves in Extrusion	☐ Drawing	☐ Out of Calibration		
☐ Turning Sequence	☐ Finish	☐ Out of Sequence		
☐ Wave/Twist in Tube	☐ Folio	☐ Outside Dimensions		

Picklist Print

October-30-12 8:48:31 AM

17

Work Order ID: 92464

92464

Parent Item: D350-636-011

D350-636-011

Parent Item Name: Skidtube LH

Start Date: 30/10/2012 **Required Date:** 13/11/2012

Start Qty: 1.00 **Required Qty:** 1.00

Comments:
IPP Rev:I 02.09.25 Rearranged procedure steps KJ
IPP Rev:J 06-03-23 As per Rev D JLM
IPP Rev:K 06-07.13 As per dsi9343 EC
IPP Rev:L 07-07-28 Added SS Wearplates(Rev E) JLM Verf:EC
IPP Rev:M 08-04-22 update steps 4, 13 DD verified by:EC
IPP Rev:N 08-09-23 revF as per dwg DD verified by:ec
IPP Rev:O 09-02-06 apply antiseize on AN8C21A bolts as per PAR09-010
DD verf:EC IPP Rev:P 10.06.22 revise
seq110 DD verf:EC IPP Rev:Q 10.10.01 as per IIN revH
DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3492-1 *D3492-1* Plug		Manufactured	No			230	Each	114.0000	8	8	**	HL 14/11/19	

Location	Loc Qty	Loc Code	
FP002	18		
69531	8		
74444	2		
76235	4		
88541	3		
89363	1		
FP-A	96		
83098	7		
91466	89		x8

DQA: ________ Date: ____________

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date:

Work Order: ____________	**DISPOSITION**	**AGAINST DEPARTMENT/PROCESS**
Part No. ____________	Rework ☐	Skid-tube ☐ Crosstube ☐ Water Jet ☐ Engineering ☐
NCR No. ____________	Scrap ☐	Machining ☐ Small Fab ☐ Prod. Eng. Coor. ☐ Quality ☐
	Use-as-is ☐	Thermoforming ☐ Finishing ☐ Rec/Store/Packaging ☐ Other ☐
	Work Order Update ☐	Large Fab ☐ Composite ☐ Supplier ☐ ☐

Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data ☐									
Equip/Tooling ☐									
Operator ☐									
Material ☐									
Setup ☐									
Other ☐									
Process ☐									
Supplier ☐									
Training ☐									
Unapproved ☐									

FAULT CATEGORY

Landing Gear	**General**			
☐ Bending	☐ Bend	☐ Grain	☐ Ovalized	☐ Pressure/Forced
☐ Centre Not Concentric to O/S	☐ BOM/Route	☐ Hardware	☐ Over/Under tolerance	☐ Temperature/Cure
☐ Cracks	☐ Broken/Damaged	☐ Inspection Incomplete	☐ Part Incorrect	☐ Weld
☐ Crushed/Crimped	☐ Burrs	☐ Instructions Incomplete/Unclear	☐ Part Lost/Missing	☐ Wrong Stock Pulled
☐ Cuffs	☐ Contamination	☐ Maintenance	☐ Part Moved	
☐ Heat Treat	☐ Countersink	☐ Mislabeled	☐ Positioned Wrong	
☐ Inspection Strip in Tube	☐ Cut Too Short	☐ Misread	☐ Power Loss/Surge	☐ Other
☐ Ripples in Bend	☐ Drill Holes	☐ Offset		
☐ Torque Waves in Extrusion	☐ Drawing	☐ Out of Calibration		
☐ Turning Sequence	☐ Finish	☐ Out of Sequence		
☐ Wave/Twist in Tube	☐ Folio	☐ Outside Dimensions		

Picklist Print

October-30-12 8:48:32 AM

Work Order ID: 92464

Parent Item: D350-636-011

Parent Item Name: Skidtube LH

92464
D350-636-011

Start Date: 30/10/2012 **Required Date:** 13/11/2012

Start Qty: 1.00 **Required Qty:** 1.00

D3492-3 | Manufactured | No | 230 | Each | 155.0000 | 8 | 8

D3492-3
Plug

**

Location		Loc Qty	Loc Code
FP001		40	
	90322	40	
FP002		40	
	89291	40	
FP-A		75	
	81967	5	
	83099	3	
	83529	4	
	85461	1	
	86865	2	
	91610	60	

NAS1611-010 | Purchased | No | 230 | Each | 336.0000 | 8 | 8

NAS1611-010
O-RING

**

Location		Loc Qty	Loc Code
FP		184	
	110915	0	
	123348	184	
FP001		152	
	110915	14	
	117460	8	
	118077	1	
	118612	3	
	119438	39	
	121259	2	
	121584	2	
	121723	7	
	122151	8	
	123352	68	

DQA: ________ Date: ____________

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date:

Work Order: ____________________

Part No. ____________________

NCR No. ____________________

DISPOSITION

- Rework ☐
- Scrap ☐
- Use-as-is ☐
- Work Order Update ☐

AGAINST DEPARTMENT/PROCESS

Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐
Machining ☐	Small Fab ☐	Prod. Eng. Coor. ☐	Quality ☐
Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐
Large Fab ☐	Composite ☐	Supplier ☐	☐

Root Cause		Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data	☐									
Equip/Tooling	☐									
Operator	☐									
Material	☐									
Setup	☐									
Other	☐									
Process	☐									
Supplier	☐									
Training	☐									
Unapproved	☐									

FAULT CATEGORY

Landing Gear	General			
☐ Bending	☐ Bend	☐ Grain	☐ Ovalized	☐ Pressure/Forced
☐ Centre Not Concentric to O/S	☐ BOM/Route	☐ Hardware	☐ Over/Under tolerance	☐ Temperature/Cure
☐ Cracks	☐ Broken/Damaged	☐ Inspection Incomplete	☐ Part Incorrect	☐ Weld
☐ Crushed/Crimped	☐ Burrs	☐ Instructions Incomplete/Unclear	☐ Part Lost/Missing	☐ Wrong Stock Pulled
☐ Cuffs	☐ Contamination	☐ Maintenance	☐ Part Moved	
☐ Heat Treat	☐ Countersink	☐ Mislabeled	☐ Positioned Wrong	
☐ Inspection Strip in Tube	☐ Cut Too Short	☐ Misread	☐ Power Loss/Surge	☐ Other
☐ Ripples in Bend	☐ Drill Holes	☐ Offset		
☐ Torque Waves in Extrusion	☐ Drawing	☐ Out of Calibration		
☐ Turning Sequence	☐ Finish	☐ Out of Sequence		
☐ Wave/Twist in Tube	☐ Folio	☐ Outside Dimensions		

Picklist Print

October-30-12 8:48:32 AM

Work Order ID: 92464 *92464*

Parent Item: D350-636-011 *D350-636-011*

Parent Item Name: Skidtube LH

Start Date: 30/10/2012 **Required Date:** 13/11/2012

Start Qty: 1.00 **Required Qty:** 1.00

NAS1149D0863J Purchased No 250 Each 129.0000 2 2

NAS1149D0863J **

WASHER

JB 12/11/23

Location	Loc Qty	Loc Code	
ST298	129		
118078	18		
119307	1		
120308	10		
121556	100		121556

SMS

D2744 Manufactured No 110 Each 51.0000 1 1

D2744 **

Cap

JG 12-10-31

Location	Loc Qty	Loc Code	
LG002	51		
62715	1		
85506	22		1
91307	28		

D2600-3-BENT Manufactured No 110 Each 35.0000 1 1

D2600-3-BENT ** 1 JB 12/10/31 X

Extrusion Bent

Location	Loc Qty	Loc Code
LG	35	
66875	7	
73253	1	
75021	1	
75022	1	
75023	1	
81330	4	
83305	1	
92049	19	

DQA: ________ Date: ____________

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date:

Work Order: ____________ Part No. ____________ NCR No. ____________	**DISPOSITION** Rework ☐ Scrap ☐ Use-as-is ☐ Work Order Update ☐	**AGAINST DEPARTMENT/PROCESS** Skid-tube ☐ Crosstube ☐ Water Jet ☐ Engineering ☐ Machining ☐ Small Fab ☐ Prod. Eng. Coor. ☐ Quality ☐ Thermoforming ☐ Finishing ☐ Rec/Store/Packaging ☐ Other ☐ Large Fab ☐ Composite ☐ Supplier ☐ ☐

Root Cause		Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data	☐									
Equip/Tooling	☐									
Operator	☐									
Material	☐									
Setup	☐									
Other	☐									
Process	☐									
Supplier	☐									
Training	☐									
Unapproved	☐									

FAULT CATEGORY

Landing Gear

- ☐ Bending
- ☐ Centre Not Concentric to O/S
- ☐ Cracks
- ☐ Crushed/Crimped
- ☐ Cuffs
- ☐ Heat Treat
- ☐ Inspection Strip in Tube
- ☐ Ripples in Bend
- ☐ Torque Waves in Extrusion
- ☐ Turning Sequence
- ☐ Wave/Twist in Tube

General

- ☐ Bend
- ☐ BOM/Route
- ☐ Broken/Damaged
- ☐ Burrs
- ☐ Contamination
- ☐ Countersink
- ☐ Cut Too Short
- ☐ Drill Holes
- ☐ Drawing
- ☐ Finish
- ☐ Folio
- ☐ Grain
- ☐ Hardware
- ☐ Inspection Incomplete
- ☐ Instructions Incomplete/Unclear
- ☐ Maintenance
- ☐ Mislabeled
- ☐ Misread
- ☐ Offset
- ☐ Out of Calibration
- ☐ Out of Sequence
- ☐ Outside Dimensions
- ☐ Ovalized
- ☐ Over/Under tolerance
- ☐ Part Incorrect
- ☐ Part Lost/Missing
- ☐ Part Moved
- ☐ Positioned Wrong
- ☐ Power Loss/Surge
- ☐ Pressure/Forced
- ☐ Temperature/Cure
- ☐ Weld
- ☐ Wrong Stock Pulled
- ☐ Other ____________

Picklist Print

Work Order ID: 92464

Parent Item: D350-636-011

Parent Item Name: Skidtube LH

92464
D350-636-011

Start Date: 30/10/2012 **Required Date:** 13/11/2012

Start Qty: 1.00 **Required Qty:** 1.00

D2743 | Manufactured | No | 160 | Each | 163.0000 | 8 | 8

D2743

Crossbolt Spacer

** BC 12-11-08

B 91619 - 8

Location		Loc Qty	Loc Code
LG		89	
	81965	23	
	83262	2	
	85459	4	
	88504	60	
LG001		74	
	67766	4	
	68251	3	
	73403	64	
	74445	1	
	79517	2	

D2739 | Manufactured | No | 160 | Each | 7.0000 | 1 | 1

D2739

350 I Beam

** DC 12/11/07

Location B92571 ①

Location		Loc Qty	Loc Code
LG		7	
	72155	1	
	81508	1	
	85487	1	
	87734	1	
	91729	3	

DQA: ________ Date: ____________

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date:

Work Order: ____________	DISPOSITION	AGAINST DEPARTMENT/PROCESS			
Part No. ____________	Rework ☐	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐
NCR No. ____________	Scrap ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coor. ☐	Quality ☐
	Use-as-is ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐
	Work Order Update ☐	Large Fab ☐	Composite ☐	Supplier ☐	☐

Root Cause		Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data	☐									
Equip/Tooling	☐									
Operator	☐									
Material	☐									
Setup	☐									
Other	☐									
Process	☐									
Supplier	☐									
Training	☐									
Unapproved	☐									

FAULT CATEGORY

Landing Gear	General			
☐ Bending	☐ Bend	☐ Grain	☐ Ovalized	☐ Pressure/Forced
☐ Centre Not Concentric to O/S	☐ BOM/Route	☐ Hardware	☐ Over/Under tolerance	☐ Temperature/Cure
☐ Cracks	☐ Broken/Damaged	☐ Inspection Incomplete	☐ Part Incorrect	☐ Weld
☐ Crushed/Crimped	☐ Burrs	☐ Instructions Incomplete/Unclear	☐ Part Lost/Missing	☐ Wrong Stock Pulled
☐ Cuffs	☐ Contamination	☐ Maintenance	☐ Part Moved	
☐ Heat Treat	☐ Countersink	☐ Mislabeled	☐ Positioned Wrong	
☐ Inspection Strip in Tube	☐ Cut Too Short	☐ Misread	☐ Power Loss/Surge	☐ Other
☐ Ripples in Bend	☐ Drill Holes	☐ Offset		
☐ Torque Waves in Extrusion	☐ Drawing	☐ Out of Calibration		
☐ Turning Sequence	☐ Finish	☐ Out of Sequence		
☐ Wave/Twist in Tube	☐ Folio	☐ Outside Dimensions		

Picklist Print

October-30-12 8:48:32 AM

Work Order ID: 92464 *92464*

Parent Item: D350-636-011 *D350-636-011*

Parent Item Name: Skidtube LH

Start Date: 30/10/2012 **Required Date:** 13/11/2012

Start Qty: 1.00 **Required Qty:** 1.00

D3490-3 | Manufactured | No | 160 | Each | 46.0000 | 4 | 4

D3490-3 **

Cross Bolt Spacer

BG 12-11-08

Location		Loc Qty	Loc Code	
LG		40		
	90352	40		4
LG001		6		
	86980	6		

D3490-1 | Manufactured | No | 160 | Each | 57.0000 | 4 | 4

D3490-1 **

Cross Bolt Spacer

BG 12-11-08

Location		Loc Qty	Loc Code	
LG		48		
	81976	2		
	86979	24		1
	88617	22		~~4~~ 3
LG001		9		
	62450	2		
	74875	4		
	77042	3		

DQA: ________ Date: ________________

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date:

Work Order: ____________________

Part No. ____________________

NCR No. ____________________

DISPOSITION

- Rework ☐
- Scrap ☐
- Use-as-is ☐
- Work Order Update ☐

AGAINST DEPARTMENT/PROCESS

Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐
Machining ☐	Small Fab ☐	Prod. Eng. Coor. ☐	Quality ☐
Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐
Large Fab ☐	Composite ☐	Supplier ☐	☐

Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data ☐									
Equip/Tooling ☐									
Operator ☐									
Material ☐									
Setup ☐									
Other ☐									
Process ☐									
Supplier ☐									
Training ☐									
Unapproved ☐									

FAULT CATEGORY

Landing Gear

- ☐ Bending
- ☐ Centre Not Concentric to O/S
- ☐ Cracks
- ☐ Crushed/Crimped
- ☐ Cuffs
- ☐ Heat Treat
- ☐ Inspection Strip in Tube
- ☐ Ripples in Bend
- ☐ Torque Waves in Extrusion
- ☐ Turning Sequence
- ☐ Wave/Twist in Tube

General

- ☐ Bend
- ☐ BOM/Route
- ☐ Broken/Damaged
- ☐ Burrs
- ☐ Contamination
- ☐ Countersink
- ☐ Cut Too Short
- ☐ Drill Holes
- ☐ Drawing
- ☐ Finish
- ☐ Folio
- ☐ Grain
- ☐ Hardware
- ☐ Inspection Incomplete
- ☐ Instructions Incomplete/Unclear
- ☐ Maintenance
- ☐ Mislabeled
- ☐ Misread
- ☐ Offset
- ☐ Out of Calibration
- ☐ Out of Sequence
- ☐ Outside Dimensions
- ☐ Ovalized
- ☐ Over/Under tolerance
- ☐ Part Incorrect
- ☐ Part Lost/Missing
- ☐ Part Moved
- ☐ Positioned Wrong
- ☐ Power Loss/Surge
- ☐ Pressure/Forced
- ☐ Temperature/Cure
- ☐ Weld
- ☐ Wrong Stock Pulled
- ☐ Other ____________________

Picklist Print

October-30-12 8:48:32 AM

Work Order ID: 92464

92464

Parent Item: D350-636-011

D350-636-011

Parent Item Name: Skidtube LH

Start Date: 30/10/2012 **Required Date:** 13/11/2012

Start Qty: 1.00 **Required Qty:** 1.00

ALS4-1032-225 Purchased No 220 Each 2,201.000 38 38

ALS4-1032-225 ** [illegible] 12/11/19

Insert

Location		Loc Qty	Loc Code	
FP-B		770		
	122290	770		X38
ST281		1408		
	108696	146		
	110768	62		
	118386	55		
	118966	68		
	121269	77		
	122827	1000		
ST282		23		
	120410	10		
	120451	13		

D3793-3 Manufactured No 230 Each 17.0000 1 1

D3793-3 ** [illegible] 12/11/19

Wearshoe

Location		Loc Qty	Loc Code	
FP001		17		
	87135	5		
	91326	12		X1

DQA: ________ Date: ____________

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date:

Work Order: ____________ Part No. ____________ NCR No. ____________	**DISPOSITION**	**AGAINST DEPARTMENT/PROCESS**			
	Rework ☐	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐
	Scrap ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coor. ☐	Quality ☐
	Use-as-is ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐
	Work Order Update ☐	Large Fab ☐	Composite ☐	Supplier ☐	☐

Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data ☐									
Equip/Tooling ☐									
Operator ☐									
Material ☐									
Setup ☐									
Other ☐									
Process ☐									
Supplier ☐									
Training ☐									
Unapproved ☐									

FAULT CATEGORY

Landing Gear	**General**			
☐ Bending	☐ Bend	☐ Grain	☐ Ovalized	☐ Pressure/Forced
☐ Centre Not Concentric to O/S	☐ BOM/Route	☐ Hardware	☐ Over/Under tolerance	☐ Temperature/Cure
☐ Cracks	☐ Broken/Damaged	☐ Inspection Incomplete	☐ Part Incorrect	☐ Weld
☐ Crushed/Crimped	☐ Burrs	☐ Instructions Incomplete/Unclear	☐ Part Lost/Missing	☐ Wrong Stock Pulled
☐ Cuffs	☐ Contamination	☐ Maintenance	☐ Part Moved	
☐ Heat Treat	☐ Countersink	☐ Mislabeled	☐ Positioned Wrong	
☐ Inspection Strip in Tube	☐ Cut Too Short	☐ Misread	☐ Power Loss/Surge	☐ Other ____________
☐ Ripples in Bend	☐ Drill Holes	☐ Offset	____________	
☐ Torque Waves in Extrusion	☐ Drawing	☐ Out of Calibration	____________	
☐ Turning Sequence	☐ Finish	☐ Out of Sequence	____________	
☐ Wave/Twist in Tube	☐ Folio	☐ Outside Dimensions		

Picklist Print

October-30-12 8:48:32 AM

Work Order ID: 92464 *92464*

Parent Item: D350-636-011 *D350-636-011*

Parent Item Name: Skidtube LH

Start Date: 30/10/2012 **Required Date:** 13/11/2012

Start Qty: 1.00 **Required Qty:** 1.00

AN8C35A | Purchased | No | 230 | Each | 15.0000 | 1 | 1

AN8C35A ** Hl 12/11/19

BOLT

Location		Loc Qty	Loc Code
FG		5	
	121275	5	
FP002		9	
	115960	1	
	121275	8	
ST346		1	X1
	114442	0	
	115188	0	
	115960	1	

D3793-1 | Manufactured | No | 230 | Each | 15.0000 | 1 | 1

D3793-1 ** Hl 12/11/19

Wearshoe

Location		Loc Qty	Loc Code
FP001		15	
	82171	2	
	87273	3	
	89999	10	X1

D3488-041 | Manufactured | No | 230 | Each | 16.0000 | 1 | 1

D3488-041 ** Hl 12/11/19

Blade Fitting Assembly, LH

Location		Loc Qty	Loc Code
FP002		16	
	83407	2	
	85733	3	X1
	88255	11	

DQA: ________ Date: ____________

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date:

	DISPOSITION	AGAINST DEPARTMENT/PROCESS			
Work Order: ____________	Rework ☐	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐
Part No. ____________	Scrap ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coor. ☐	Quality ☐
	Use-as-is ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐
NCR No. ____________	Work Order Update ☐	Large Fab ☐	Composite ☐	Supplier ☐	☐

Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data ☐									
Equip/Tooling ☐									
Operator ☐									
Material ☐									
Setup ☐									
Other ☐									
Process ☐									
Supplier ☐									
Training ☐									
Unapproved ☐									

FAULT CATEGORY

Landing Gear	General			
☐ Bending	☐ Bend	☐ Grain	☐ Ovalized	☐ Pressure/Forced
☐ Centre Not Concentric to O/S	☐ BOM/Route	☐ Hardware	☐ Over/Under tolerance	☐ Temperature/Cure
☐ Cracks	☐ Broken/Damaged	☐ Inspection Incomplete	☐ Part Incorrect	☐ Weld
☐ Crushed/Crimped	☐ Burrs	☐ Instructions Incomplete/Unclear	☐ Part Lost/Missing	☐ Wrong Stock Pulled
☐ Cuffs	☐ Contamination	☐ Maintenance	☐ Part Moved	
☐ Heat Treat	☐ Countersink	☐ Mislabeled	☐ Positioned Wrong	
☐ Inspection Strip in Tube	☐ Cut Too Short	☐ Misread	☐ Power Loss/Surge	☐ Other ____________
☐ Ripples in Bend	☐ Drill Holes	☐ Offset		
☐ Torque Waves in Extrusion	☐ Drawing	☐ Out of Calibration		
☐ Turning Sequence	☐ Finish	☐ Out of Sequence		
☐ Wave/Twist in Tube	☐ Folio	☐ Outside Dimensions		

Picklist Print

October-30-12 8:48:32 AM

Work Order ID: 92464

92464

Parent Item: D350-636-011

D350-636-011

Parent Item Name: Skidtube LH

Start Date: 30/10/2012 **Required Date:** 13/11/2012

Start Qty: 1.00 **Required Qty:** 1.00

D3794-3 Manufactured No 230 Each 9.0000 1 1

D3794-3

Gasket

** Al 12/11/12

Location	Loc Qty	Loc Code	
FP002	9	B91855	x1
74530	2		
86243	7		

AN6C44A Purchased No 230 Each 58.0000 4 4

AN6C44A

BOLT

** Al 12/11/12

Location	Loc Qty	Loc Code	
FG	2		
103964	2		
ST340	38		
122491	38		x✓
ST341	4		
122843	4		
ST343	14		
121013	11		
121167	2		
122204	1		

DQA: ________ Date: ____________

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date:

Work Order: ____________	**DISPOSITION**	**AGAINST DEPARTMENT/PROCESS**			
Part No. ____________	Rework ☐	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐
NCR No. ____________	Scrap ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coor. ☐	Quality ☐
	Use-as-is ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐
	Work Order Update ☐	Large Fab ☐	Composite ☐	Supplier ☐	☐

Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data ☐									
Equip/Tooling ☐									
Operator ☐									
Material ☐									
Setup ☐									
Other ☐									
Process ☐									
Supplier ☐									
Training ☐									
Unapproved ☐									

FAULT CATEGORY

Landing Gear	General			
☐ Bending	☐ Bend	☐ Grain	☐ Ovalized	☐ Pressure/Forced
☐ Centre Not Concentric to O/S	☐ BOM/Route	☐ Hardware	☐ Over/Under tolerance	☐ Temperature/Cure
☐ Cracks	☐ Broken/Damaged	☐ Inspection Incomplete	☐ Part Incorrect	☐ Weld
☐ Crushed/Crimped	☐ Burrs	☐ Instructions Incomplete/Unclear	☐ Part Lost/Missing	☐ Wrong Stock Pulled
☐ Cuffs	☐ Contamination	☐ Maintenance	☐ Part Moved	
☐ Heat Treat	☐ Countersink	☐ Mislabeled	☐ Positioned Wrong	
☐ Inspection Strip in Tube	☐ Cut Too Short	☐ Misread	☐ Power Loss/Surge	☐ Other ____
☐ Ripples in Bend	☐ Drill Holes	☐ Offset	____________	
☐ Torque Waves in Extrusion	☐ Drawing	☐ Out of Calibration	____________	
☐ Turning Sequence	☐ Finish	☐ Out of Sequence	____________	
☐ Wave/Twist in Tube	☐ Folio	☐ Outside Dimensions		

Picklist Print

October-30-12 8:48:32 AM

Work Order ID: 92464

Parent Item: D350-636-011

Parent Item Name: Skidtube LH

92464

D350-636-011

Start Date: 30/10/2012 **Required Date:** 13/11/2012

Start Qty: 1.00 **Required Qty:** 1.00

MS21083C8	Purchased	No	230	Each	50.0000	1	1

MS21083C8

NUT

** Gl 11/11/19

Location		Loc Qty	Loc Code	
318		2		
	122452	2		
FP002		1		
	115884	1		
ST303		4		
	115884	0		
	118077	1		
	119309	2		
	119638	1		
ST319		38		
	123346	38		
ST321		5		V1
	122141	5		

D3536-25	Manufactured	No	230	Each	8.0000	1	1

D3536-25

Gasket

** Gl 11/11/19

Location		Loc Qty	Loc Code	
FG		2	B91814	V1
	87053	2		
FP		1		
	83900	1		
FP002		5		
	89057	1		
	90820	4		

DQA: ________ Date: ____________

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date:

Work Order: ____________________

Part No. ____________________

NCR No. ____________________

DISPOSITION

- Rework ☐
- Scrap ☐
- Use-as-is ☐
- Work Order Update ☐

AGAINST DEPARTMENT/PROCESS

Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐
Machining ☐	Small Fab ☐	Prod. Eng. Coor. ☐	Quality ☐
Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐
Large Fab ☐	Composite ☐	Supplier ☐	☐

Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data ☐									
Equip/Tooling ☐									
Operator ☐									
Material ☐									
Setup ☐									
Other ☐									
Process ☐									
Supplier ☐									
Training ☐									
Unapproved ☐									

FAULT CATEGORY

Landing Gear	General			
☐ Bending	☐ Bend	☐ Grain	☐ Ovalized	☐ Pressure/Forced
☐ Centre Not Concentric to O/S	☐ BOM/Route	☐ Hardware	☐ Over/Under tolerance	☐ Temperature/Cure
☐ Cracks	☐ Broken/Damaged	☐ Inspection Incomplete	☐ Part Incorrect	☐ Weld
☐ Crushed/Crimped	☐ Burrs	☐ Instructions Incomplete/Unclear	☐ Part Lost/Missing	☐ Wrong Stock Pulled
☐ Cuffs	☐ Contamination	☐ Maintenance	☐ Part Moved	
☐ Heat Treat	☐ Countersink	☐ Mislabeled	☐ Positioned Wrong	
☐ Inspection Strip in Tube	☐ Cut Too Short	☐ Misread	☐ Power Loss/Surge	☐ Other
☐ Ripples in Bend	☐ Drill Holes	☐ Offset		
☐ Torque Waves in Extrusion	☐ Drawing	☐ Out of Calibration		
☐ Turning Sequence	☐ Finish	☐ Out of Sequence		
☐ Wave/Twist in Tube	☐ Folio	☐ Outside Dimensions		

Picklist Print

October-30-12 8:48:32 AM

Work Order ID: 92464

92464

Parent Item: D350-636-011

D350-636-011

Parent Item Name: Skidtube LH

Start Date: 30/10/2012 **Required Date:** 13/11/2012

Start Qty: 1.00 **Required Qty:** 1.00

Item	Alt	Type		UOM Qty	UOM	Cost	Qty	Picked
D3631-1 *D3631-1* Washer		Manufactured	No	230	Each	123.0000	8	8

** Ml 12/11/12

Location		Loc Qty	Loc Code	
FG		20		
	81874	2		
	83588	18		
FP-A		88		
	91606	88		
ST072		15		X8
	68062	2		
	75548	13		

Item	Alt	Type		UOM Qty	UOM	Cost	Qty	Picked
D3791-1 *D3791-1* Wearplate		Manufactured	No	230	Each	10.0000	1	1

** Ml 12/11/12

Location		Loc Qty	Loc Code	
FP001		7		
	89244	7		X1
FP002		3		
	62239	2		
	83392	1		

Item	Alt	Type		UOM Qty	UOM	Cost	Qty	Picked
AN960C10L *AN960C10L* washer	NAS1149C0332 R	Purchased	No	230	Each	21.0000	38	38

** Ml 12/11/12

Location		Loc Qty	Loc Code	
ST		21	M123355	X38
	107534	21		

DQA: ________ Date: ____________

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date:

Work Order: ____________ Part No. ____________ NCR No. ____________	**DISPOSITION** Rework ☐ Scrap ☐ Use-as-is ☐ Work Order Update ☐	**AGAINST DEPARTMENT/PROCESS** Skid-tube ☐ Crosstube ☐ Water Jet ☐ Engineering ☐ Machining ☐ Small Fab ☐ Prod. Eng. Coor. ☐ Quality ☐ Thermoforming ☐ Finishing ☐ Rec/Store/Packaging ☐ Other ☐ Large Fab ☐ Composite ☐ Supplier ☐ ☐

Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data ☐ Equip/Tooling ☐ Operator ☐ Material ☐ Setup ☐ Other ☐ Process ☐ Supplier ☐ Training ☐ Unapproved ☐									

FAULT CATEGORY

Landing Gear

- ☐ Bending
- ☐ Centre Not Concentric to O/S
- ☐ Cracks
- ☐ Crushed/Crimped
- ☐ Cuffs
- ☐ Heat Treat
- ☐ Inspection Strip in Tube
- ☐ Ripples in Bend
- ☐ Torque Waves in Extrusion
- ☐ Turning Sequence
- ☐ Wave/Twist in Tube

General

- ☐ Bend
- ☐ BOM/Route
- ☐ Broken/Damaged
- ☐ Burrs
- ☐ Contamination
- ☐ Countersink
- ☐ Cut Too Short
- ☐ Drill Holes
- ☐ Drawing
- ☐ Finish
- ☐ Folio
- ☐ Grain
- ☐ Hardware
- ☐ Inspection Incomplete
- ☐ Instructions Incomplete/Unclear
- ☐ Maintenance
- ☐ Mislabeled
- ☐ Misread
- ☐ Offset
- ☐ Out of Calibration
- ☐ Out of Sequence
- ☐ Outside Dimensions
- ☐ Ovalized
- ☐ Over/Under tolerance
- ☐ Part Incorrect
- ☐ Part Lost/Missing
- ☐ Part Moved
- ☐ Positioned Wrong
- ☐ Power Loss/Surge
- ☐ Pressure/Forced
- ☐ Temperature/Cure
- ☐ Weld
- ☐ Wrong Stock Pulled
- ☐ Other ____________

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Picklist Print

October-30-12 8:48:32 AM

Work Order ID: 92464 *92464*

Parent Item: D350-636-011 *D350-636-011*

Parent Item Name: Skidtube LH

Start Date: 30/10/2012 **Required Date:** 13/11/2012

Start Qty: 1.00 **Required Qty:** 1.00

D2745 Manufactured No 230 Each 30.0000 8 8

D2745 ** Hl 11/11/19

Bushing

Location		Loc Qty	Loc Code	
FP		26	B92539	V8
	79518	6		
	87527	4		
	89303	16		
FP001		4		
	69529	1		
	76142	1		
	83260	2		

AN3C5A Purchased No 230 Each 414.0000 34 34

AN3C5A ** Hl 12/11/19

Bolt

Location		Loc Qty	Loc Code	
FG		5		
	122800	5	X1 123741	V34
ST512		409		
	115835	7		
	116419	28		
	117343	13		
	117764	7		
	117872	2		
	119749	23		
	120423	28		
	121255	23		
	121708	179		
	122141	80		
	122800	19		

DQA: ________ Date: ____________

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date:

Work Order: ______	**DISPOSITION**	**AGAINST DEPARTMENT/PROCESS**			
Part No. ______	Rework ☐	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐
NCR No. ______	Scrap ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coor. ☐	Quality ☐
	Use-as-is ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐
	Work Order Update ☐	Large Fab ☐	Composite ☐	Supplier ☐	☐

Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data ☐									
Equip/Tooling ☐									
Operator ☐									
Material ☐									
Setup ☐									
Other ☐									
Process ☐									
Supplier ☐									
Training ☐									
Unapproved ☐									

FAULT CATEGORY

Landing Gear	**General**			
☐ Bending	☐ Bend	☐ Grain	☐ Ovalized	☐ Pressure/Forced
☐ Centre Not Concentric to O/S	☐ BOM/Route	☐ Hardware	☐ Over/Under tolerance	☐ Temperature/Cure
☐ Cracks	☐ Broken/Damaged	☐ Inspection Incomplete	☐ Part Incorrect	☐ Weld
☐ Crushed/Crimped	☐ Burrs	☐ Instructions Incomplete/Unclear	☐ Part Lost/Missing	☐ Wrong Stock Pulled
☐ Cuffs	☐ Contamination	☐ Maintenance	☐ Part Moved	
☐ Heat Treat	☐ Countersink	☐ Mislabeled	☐ Positioned Wrong	
☐ Inspection Strip in Tube	☐ Cut Too Short	☐ Misread	☐ Power Loss/Surge	☐ Other ______
☐ Ripples in Bend	☐ Drill Holes	☐ Offset	______	
☐ Torque Waves in Extrusion	☐ Drawing	☐ Out of Calibration	______	
☐ Turning Sequence	☐ Finish	☐ Out of Sequence	______	
☐ Wave/Twist in Tube	☐ Folio	☐ Outside Dimensions		

Picklist Print

October-30-12 8:48:32 AM

Work Order ID: 92464   *92464*

Parent Item: D350-636-011   *D350-636-011*

Parent Item Name: Skidtube LH

Start Date: 30/10/2012   **Required Date:** 13/11/2012

Start Qty: 1.00   **Required Qty:** 1.00

D3537-1   Manufactured   No   230   Each   60.0000   3   3

D3537-1   **   gl 11/11/14

Wearpad

Location		Loc Qty	Loc Code	
FG		2	B91645	x3
	88562	2		
FP001		46		
	90197	22		
	91668	24		
FP002		12		
	83254	1		
	83255	3		
	87697	1		
	88562	7		

NAS1149C0832R   Purchased   No   230   Each   396.0000   1   1

NAS1149C0832R   **   gl 11/11/14

WASHER

Location		Loc Qty	Loc Code	
296		200		
	122441	200		
ST297		196		
	114915	196		x1

DQA: ________ Date: ____________

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date:

Work Order: ______ Part No. ______ NCR No. ______	**DISPOSITION** Rework ☐ Scrap ☐ Use-as-is ☐ Work Order Update ☐	**AGAINST DEPARTMENT/PROCESS** Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Crosstube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coor. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐ ☐

Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data ☐									
Equip/Tooling ☐									
Operator ☐									
Material ☐									
Setup ☐									
Other ☐									
Process ☐									
Supplier ☐									
Training ☐									
Unapproved ☐									

FAULT CATEGORY

Landing Gear

- ☐ Bending
- ☐ Centre Not Concentric to O/S
- ☐ Cracks
- ☐ Crushed/Crimped
- ☐ Cuffs
- ☐ Heat Treat
- ☐ Inspection Strip in Tube
- ☐ Ripples in Bend
- ☐ Torque Waves in Extrusion
- ☐ Turning Sequence
- ☐ Wave/Twist in Tube

General

- ☐ Bend
- ☐ BOM/Route
- ☐ Broken/Damaged
- ☐ Burrs
- ☐ Contamination
- ☐ Countersink
- ☐ Cut Too Short
- ☐ Drill Holes
- ☐ Drawing
- ☐ Finish
- ☐ Folio
- ☐ Grain
- ☐ Hardware
- ☐ Inspection Incomplete
- ☐ Instructions Incomplete/Unclear
- ☐ Maintenance
- ☐ Mislabeled
- ☐ Misread
- ☐ Offset
- ☐ Out of Calibration
- ☐ Out of Sequence
- ☐ Outside Dimensions
- ☐ Ovalized
- ☐ Over/Under tolerance
- ☐ Part Incorrect
- ☐ Part Lost/Missing
- ☐ Part Moved
- ☐ Positioned Wrong
- ☐ Power Loss/Surge
- ☐ Pressure/Forced
- ☐ Temperature/Cure
- ☐ Weld
- ☐ Wrong Stock Pulled
- ☐ Other ____________

Picklist Print

October-30-12 8:48:32 AM

Work Order ID: 92464

Parent Item: D350-636-011

Parent Item Name: Skidtube LH

92464
D350-636-011

Start Date: 30/10/2012 **Required Date:** 13/11/2012
Start Qty: 1.00 **Required Qty:** 1.00

AN3C6A | Purchased | No | 230 | Each | 979.0000 | 4 | 4

AN3C6A ** Jl 12/11/14

BOLT

Location		Loc Qty	Loc Code	
FG		10		
	122416	10		
FP001		1		
	111982	1		
ST512		968		
	111982	2		
	116419	23		
	116549	2		
	116704	12		
	117619	10		
	117688	1		
	117872	5		
	118422	13		
	119449	21		
	120423	3		
	120693	34		
	121682	4		
	122416	338		
	122599	500		x4

NAS1611-013 | Purchased | No | 230 | Each | 128.0000 | 8 | 8

NAS1611-013 ** Jl 12/11/14

O-RING

Location		Loc Qty	Loc Code	
FP001		128		
	116582	5		
	117291	2		
	117887	53		
	119623	36		
	121825	10	M123741	x8
	122993	22		

DQA: ________ Date: ____________

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date:

	DISPOSITION	AGAINST DEPARTMENT/PROCESS
Work Order: ____________	Rework ☐	Skid-tube ☐ Crosstube ☐ Water Jet ☐ Engineering ☐
Part No. ____________	Scrap ☐	Machining ☐ Small Fab ☐ Prod. Eng. Coor. ☐ Quality ☐
NCR No. ____________	Use-as-is ☐	Thermoforming ☐ Finishing ☐ Rec/Store/Packaging ☐ Other ☐
	Work Order Update ☐	Large Fab ☐ Composite ☐ Supplier ☐ ☐

Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data ☐									
Equip/Tooling ☐									
Operator ☐									
Material ☐									
Setup ☐									
Other ☐									
Process ☐									
Supplier ☐									
Training ☐									
Unapproved ☐									

FAULT CATEGORY

Landing Gear	General			
☐ Bending	☐ Bend	☐ Grain	☐ Ovalized	☐ Pressure/Forced
☐ Centre Not Concentric to O/S	☐ BOM/Route	☐ Hardware	☐ Over/Under tolerance	☐ Temperature/Cure
☐ Cracks	☐ Broken/Damaged	☐ Inspection Incómplete	☐ Part Incorrect	☐ Weld
☐ Crushed/Crimped	☐ Burrs	☐ Instructions Incomplete/Unclear	☐ Part Lost/Missing	☐ Wrong Stock Pulled
☐ Cuffs	☐ Contamination	☐ Maintenance	☐ Part Moved	
☐ Heat Treat	☐ Countersink	☐ Mislabeled	☐ Positioned Wrong	
☐ Inspection Strip in Tube	☐ Cut Too Short	☐ Misread	☐ Power Loss/Surge	☐ Other
☐ Ripples in Bend	☐ Drill Holes	☐ Offset	____________	
☐ Torque Waves in Extrusion	☐ Drawing	☐ Out of Calibration	____________	
☐ Turning Sequence	☐ Finish	☐ Out of Sequence	____________	
☐ Wave/Twist in Tube	☐ Folio	☐ Outside Dimensions		

Picklist Print

October-30-12 8:48:32 AM

Work Order ID: 92464 *92464*

Parent Item: D350-636-011 *D350-636-011*

Parent Item Name: Skidtube LH

Start Date: 30/10/2012 **Required Date:** 13/11/2012

Start Qty: 1.00 **Required Qty:** 1.00

D3535-25 | Manufactured | No | 230 | Each | 17.0000 | 1 | 1

D3535-25 ** GL 12/11/19

Wearshoe

Location	Loc Qty	Loc Code	
FP001	17		
62233	1		
81357	1		
87385	6		
90061	9		X1

D3794-1 | Manufactured | No | 230 | Each | 14.0000 | 1 | 1

D3794-1 ** GL 12/11/19

Gasket

Location	Loc Qty	Loc Code	
FP	2		
87631	2		
FP012	12		
90163	12		X1

MS21043-6 | Purchased | No | 230 | Each | 408.0000 | 4 | 4

MS21043-6 ** GL 12/11/19

NUT

Location	Loc Qty	Loc Code	
FG	20		
103693	20		
ST301	388		
117887	4		
120308	384		X4

DQA: ________ Date: ____________

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date:

Work Order: ____________	**DISPOSITION**	**AGAINST DEPARTMENT/PROCESS**			
Part No. ____________	Rework ☐	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐
NCR No. ____________	Scrap ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coor. ☐	Quality ☐
	Use-as-is ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐
	Work Order Update ☐	Large Fab ☐	Composite ☐	Supplier ☐	☐

Root Cause		Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data	☐									
Equip/Tooling	☐									
Operator	☐									
Material	☐									
Setup	☐									
Other	☐									
Process	☐									
Supplier	☐									
Training	☐									
Unapproved	☐									

FAULT CATEGORY

Landing Gear	**General**			
☐ Bending	☐ Bend	☐ Grain	☐ Ovalized	☐ Pressure/Forced
☐ Centre Not Concentric to O/S	☐ BOM/Route	☐ Hardware	☐ Over/Under tolerance	☐ Temperature/Cure
☐ Cracks	☐ Broken/Damaged	☐ Inspection Incomplete	☐ Part Incorrect	☐ Weld
☐ Crushed/Crimped.	☐ Burrs	☐ Instructions Incomplete/Unclear	☐ Part Lost/Missing	☐ Wrong Stock Pulled
☐ Cuffs	☐ Contamination	☐ Maintenance	☐ Part Moved	
☐ Heat Treat	☐ Countersink	☐ Mislabeled	☐ Positioned Wrong	
☐ Inspection Strip in Tube	☐ Cut Too Short	☐ Misread	☐ Power Loss/Surge	☐ Other ________
☐ Ripples in Bend	☐ Drill Holes	☐ Offset	____________	
☐ Torque Waves in Extrusion	☐ Drawing	☐ Out of Calibration	____________	
☐ Turning Sequence	☐ Finish	☐ Out of Sequence	____________	
☐ Wave/Twist in Tube	☐ Folio	☐ Outside Dimensions		

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Picklist Print

October-30-12 8:48:32 AM

Work Order ID: 92464

92464

Parent Item: D350-636-011

D350-636-011

Parent Item Name: Skidtube LH

Start Date: 30/10/2012 **Required Date:** 13/11/2012

Start Qty: 1.00 **Required Qty:** 1.00

D3493-1 Manufactured No 250 Each 5.0000 2 2

D3493-1 ** 92533 JB

Washer

Location		Loc Qty	Loc Code
ST052		5	
	77573	1	
	82023	2	
	83097	2	

ONLY INSTALL IF INSTALLING ON APICAL FLOAT SYSTEM

MS21083C8 Purchased No 250 Each 50.0000 2 2

MS21083C8 ** JB 12/11/23

NUT

Location		Loc Qty	Loc Code
318		2	
	122452	2	
FP002		1	
	115884	1	
ST303		4	
	115884	0	
	118077	1	
	119309	2	
	119638	1	
ST319		38	
	123346	38	123346
ST321		5	
	122141	5	

DQA: ________ Date: ____________

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date:

Work Order: ____________	**DISPOSITION**	**AGAINST DEPARTMENT/PROCESS**			
Part No. ____________	Rework ☐	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐
NCR No. ____________	Scrap ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coor. ☐	Quality ☐
	Use-as-is ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐
	Work Order Update ☐	Large Fab ☐	Composite ☐	Supplier ☐	☐

Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data ☐									
Equip/Tooling ☐									
Operator ☐									
Material ☐									
Setup ☐									
Other ☐									
Process ☐									
Supplier ☐									
Training ☐									
Unapproved ☐									

FAULT CATEGORY

Landing Gear	**General**			
☐ Bending	☐ Bend	☐ Grain	☐ Ovalized	☐ Pressure/Forced
☐ Centre Not Concentric to O/S	☐ BOM/Route	☐ Hardware	☐ Over/Under tolerance	☐ Temperature/Cure
☐ Cracks	☐ Broken/Damaged	☐ Inspection Incomplete	☐ Part Incorrect	☐ Weld
☐ Crushed/Crimped	☐ Burrs	☐ Instructions Incomplete/Unclear	☐ Part Lost/Missing	☐ Wrong Stock Pulled
☐ Cuffs	☐ Contamination	☐ Maintenance	☐ Part Moved	
☐ Heat Treat	☐ Countersink	☐ Mislabeled	☐ Positioned Wrong	
☐ Inspection Strip in Tube	☐ Cut Too Short	☐ Misread	☐ Power Loss/Surge	☐ Other ____
☐ Ripples in Bend	☐ Drill Holes	☐ Offset	____	
☐ Torque Waves in Extrusion	☐ Drawing	☐ Out of Calibration	____	
☐ Turning Sequence	☐ Finish	☐ Out of Sequence	____	
☐ Wave/Twist in Tube	☐ Folio	☐ Outside Dimensions		

Picklist Print

October-30-12 8:48:32 AM

Work Order ID: 92464 *92464*

Parent Item: D350-636-011 *D350-636-011*

Parent Item Name: Skidtube LH

Start Date: 30/10/2012 **Required Date:** 13/11/2012

Start Qty: 1.00 **Required Qty:** 1.00

AN8C21A — Purchased — No — 250 — Each — 6.0000 — 2 — 2 ✓

AN8C21A

BOLT

** 123642 JB

Location		Loc Qty	Loc Code
ST341		5	
	122519	5	
ST343		1	
	118758	1	

NAS1515H3L — Purchased — No — 230 — Each — 167.0000 — 4 — 4

NAS1515H3L

WASHER

**

Location		Loc Qty	Loc Code
FG		40	
	102472	40	
ST277		127	
	118686	3	
	120360	11	
	121556	45	
	122151	68	XJ

D2741 — Manufactured — No — 250 — Each — 44.0000 — 0 — 1 ✓

D2741

Blade, 350 Skidtube

** JB 12/11/23

Location		Loc Qty	Loc Code
FG		1	
	85480	1	
ST466		43	
	71856	1	
	85480	4	
	88824	38	88824

DQA: ________ Date: ____________

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date:

	DISPOSITION	AGAINST DEPARTMENT/PROCESS			
Work Order: ____________	Rework ☐	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐
Part No. ____________	Scrap ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coor. ☐	Quality ☐
	Use-as-is ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐
NCR No. ____________	Work Order Update ☐	Large Fab ☐	Composite ☐	Supplier ☐	☐

Root Cause		Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data	☐									
Equip/Tooling	☐									
Operator	☐									
Material	☐									
Setup	☐									
Other	☐									
Process	☐									
Supplier	☐									
Training	☐									
Unapproved	☐									

FAULT CATEGORY

Landing Gear	General			
☐ Bending	☐ Bend	☐ Grain	☐ Ovalized	☐ Pressure/Forced
☐ Centre Not Concentric to O/S	☐ BOM/Route	☐ Hardware	☐ Over/Under tolerance	☐ Temperature/Cure
☐ Cracks	☐ Broken/Damaged	☐ Inspection Incomplete	☐ Part Incorrect	☐ Weld
☐ Crushed/Crimped.	☐ Burrs	☐ Instructions Incomplete/Unclear	☐ Part Lost/Missing	☐ Wrong Stock Pulled
☐ Cuffs	☐ Contamination	☐ Maintenance	☐ Part Moved	
☐ Heat Treat	☐ Countersink	☐ Mislabeled	☐ Positioned Wrong	
☐ Inspection Strip in Tube	☐ Cut Too Short	☐ Misread	☐ Power Loss/Surge	☐ Other
☐ Ripples in Bend	☐ Drill Holes	☐ Offset	____________	
☐ Torque Waves in Extrusion	☐ Drawing	☐ Out of Calibration	____________	
☐ Turning Sequence	☐ Finish	☐ Out of Sequence	____________	
☐ Wave/Twist in Tube	☐ Folio	☐ Outside Dimensions		

Picklist Print

October-30-12 8:48:32 AM

Work Order ID: 92464 *92464*

Parent Item: D350-636-011 *D350-636-011*

Parent Item Name: Skidtube LH

Start Date: 30/10/2012 **Required Date:** 13/11/2012

Start Qty: 1.00 **Required Qty:** 1.00

D3532-1 Manufactured No 250 Each 20.0000 2 2

D3532-1 **

Spacer

SmD J.B 12/11/23

Location		Loc Qty	Loc Code
ST055		20	
	85484	8	
	91324	12	91324

DQA: ________ Date: ________________

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date:

Work Order: ______ Part No. ______ NCR No. ______	**DISPOSITION** Rework ☐ Scrap ☐ Use-as-is ☐ Work Order Update ☐	**AGAINST DEPARTMENT/PROCESS** Skid-tube ☐ Crosstube ☐ Water Jet ☐ Engineering ☐ Machining ☐ Small Fab ☐ Prod. Eng. Coor. ☐ Quality ☐ Thermoforming ☐ Finishing ☐ Rec/Store/Packaging ☐ Other ☐ Large Fab ☐ Composite ☐ Supplier ☐ ☐

Root Cause		Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data	☐									
Equip/Tooling	☐									
Operator	☐									
Material	☐									
Setup	☐									
Other	☐									
Process	☐									
Supplier	☐									
Training	☐									
Unapproved	☐									

FAULT CATEGORY

Landing Gear

- ☐ Bending
- ☐ Centre Not Concentric to O/S
- ☐ Cracks
- ☐ Crushed/Crimped
- ☐ Cuffs
- ☐ Heat Treat
- ☐ Inspection Strip in Tube
- ☐ Ripples in Bend
- ☐ Torque Waves in Extrusion
- ☐ Turning Sequence
- ☐ Wave/Twist in Tube

General

- ☐ Bend
- ☐ BOM/Route
- ☐ Broken/Damaged
- ☐ Burrs
- ☐ Contamination
- ☐ Countersink
- ☐ Cut Too Short
- ☐ Drill Holes
- ☐ Drawing
- ☐ Finish
- ☐ Folio
- ☐ Grain
- ☐ Hardware
- ☐ Inspection Incomplete
- ☐ Instructions Incomplete/Unclear
- ☐ Maintenance
- ☐ Mislabeled
- ☐ Misread
- ☐ Offset
- ☐ Out of Calibration
- ☐ Out of Sequence
- ☐ Outside Dimensions
- ☐ Ovalized
- ☐ Over/Under tolerance
- ☐ Part Incorrect
- ☐ Part Lost/Missing
- ☐ Part Moved
- ☐ Positioned Wrong
- ☐ Power Loss/Surge
- ☐ Pressure/Forced
- ☐ Temperature/Cure
- ☐ Weld
- ☐ Wrong Stock Pulled
- ☐ Other ________________

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QTY -041	QTY -042	QTY -043	QTY -044	PART NUMBER	DESCRIPTION
X				D2750-041	350 SKIDTUBE ASSEMBLY, LH
	X			D2750-042	350 SKIDTUBE ASSEMBLY, RH
		X		D2750-043	350 SKIDTUBE ASSEMBLY, LH
			X	D2750-044	350 SKIDTUBE ASSEMBLY, RH
1	1	1	1	D2739	WEB
8	8	8	8	D2743	SPACER
1	1	1	1	D2744	CAP
8	8	8	8	D2745	BUSHING
1				D2750-1	SKIDTUBE WELDMENT, LH
	1			D2750-2	SKIDTUBE WELDMENT, RH
		1		D2750-3	SKIDTUBE WELDMENT, LH
			1	D2750-4	SKIDTUBE WELDMENT, RH
1		1		D3488-041	BLADE FITTING, LH
	1		1	D3488-042	BLADE FITTING, RH
4	4	4	4	D3490-1	SPACER
4	4			D3490-3	SPACER
		4	4	D3490-5	SPACER
8	8	8	8	D3492-041	PLUG ASSEMBLY
8	8			D3492-043	PLUG ASSEMBLY
		8	8	D3492-045	PLUG ASSEMBLY
1	1	1	1	D3535-25	WEARSHOE
1	1	1	1	D3536-25	GASKET
3	3	3	3	D3537-1	WEARPAD
8	8	8	8	D3631-1	WASHER
1	1	1	1	D3791-1	WEARPLATE
1	1	1	1	D3793-1	WEARSHOE
1	1	1	1	D3793-3	WEARSHOE
1	1	1	1	D3794-1	GASKET
1	1	1	1	D3794-3	GASKET
38	38	38	38	ALS4-1032-225	INSERT (OR ALS7-1032-225, AKS4-1032-225, AELS-1032-225)
34	34	34	34	AN3C5A	BOLT
4	4	4	4	AN3C6A	BOLT
4	4	4	4	AN6C44A	BOLT
1	1	1	1	AN8C35A	BOLT
38	38	38	38	AN960C10L	WASHER
1	1	1	1	AN960C816L	WASHER
4	4	4	4	MS21043-6	NUT
1	1	1	1	MS21083C8	NUT
4	4	4	4	NAS1515H3L	WASHER

GENERAL NOTES:

1) MATERIAL: MAKE D2750-1/-2/-3/-4 FROM D2600-3 EXTRUSION (INITIAL LENGTH = 120.0).
2) FINISH:
   ACID ETCH, ALONDE ASSEMBLY PER DART QSI 005 4.1 PRIOR TO INSTALLING D2739 WEB.
   POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3
   BLACK ANTI-SKID PAINT AS INDICATED TO 1.0 ABOVE SKIDTUBE CENTER-LINE PER DART 005 4.4 (OPTIONAL).
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: N/A
6) IDENTIFICATION: N/A
7) WEIGHT: D2750-041/-042/-043/-044 = 26.5 LBS
8) WELD PER DART QSI 004
9) INSTALL ALS4-1032-225 INSERTS AFTER FINISH AS INDICATED. DRILL 'F' SIZE HOLES (Ø0.297) FOR WEARSHOE INSERTS
10) FINAL CONFIGURATION SHOULD HAVE THE FOLLOWING MINIMUM MECHANICAL PROPERTIES:
    MINIMUM YIELD TENSILE STRENGTH = 35 KSI
    MINIMUM ULTIMATE TENSILE STRENGTH = 38 KSI
11) SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES "LPS-3" AFTER FINISH AND AFTER INSTALLATION OF INSERTS. COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF POWDER COATING WITH MEK DEGREASER.
12) SPACER AND PLUG INSTALLED SAME AS SECTION AJ-AJ EXCEPT HORIZONTAL (F)
13) SPACER AND PLUG INSTALLED SAME AS SECTION AP-AP EXCEPT HORIZONTAL

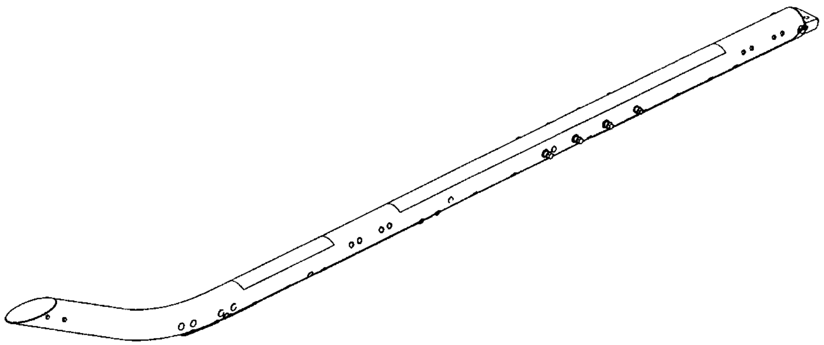
SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO 92464 HLJ
12-10-30

RELEASED

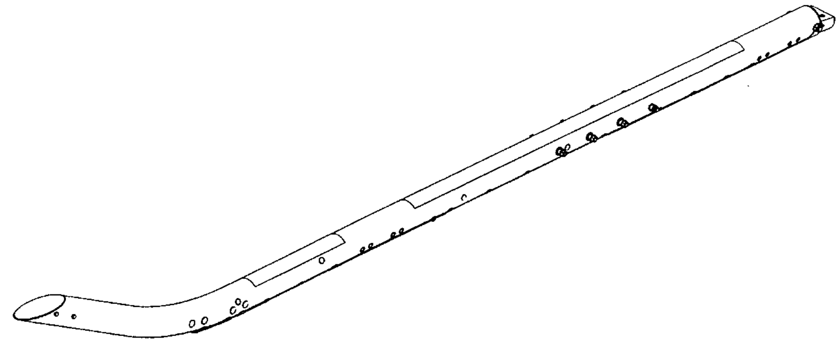
REV.	DESCRIPTION	BY	DATE
F	INCORPORATE DSI 9413; QTY (3) D3537-1 WAS QTY (5) (ZN C8-1); D3791-1/-3 REPLACES D3535-13/-35 (ZN C8-1); D3794-1/-3 REPLACES D3536-13/-35 (ZN B8-1); ADD D3791-1 (ZN C8-1); WEARSHOE HOLES UNDER FWD/AFT SADDLE REMOVED (8 PL), WEARSHOE HARDWARE QTY UPDATED (ZN B8-1); D3488-041/-042 HARDWARE UPDATED (ZN C1-8, 9, 10, 11); ADD NOTE 12 AND 13 (ZN A6-1); REASON: REF. NCR 08-043	PH	08.07.16
E	CHANGE TO STAINLESS STEEL WEARPLATES; ADD RUBBER GASKETS; CHANGE INSERTS; ADD D3631-1; REMOVE QTY (38) NAS1515H3L; REMOVE QTY (10) NAS1515H8L; REMOVE D2741, QTY (2) AN960C816; REMOVE QTY (2) MS21083C8	CB	07.05.17
D	ADD HOLES AND SPACERS FOR APICAL FLOATS; INCORPORATE DEO 9133/9157	PH	06.01.05
C	ADD D2750-3/D2750-4; INCORPORATE D2738 AND D2740	CP	98.11.18
B	CHANGE MS24694-S293 TO AN8-16A	CP	98.09.01
A	NEW ISSUE	DS	98.04.16

DESIGN	PH	**DART AEROSPACE USA, INC.** PORT HADLOCK, WA
DRAWN	RH	
CHECKED		DRAWING NO. D2750 — REV. F — SHEET 1 OF 11
MFG. APPR.		
APPROVED		TITLE 350 SKIDTUBE ASSEMBLY — SCALE NTS
DE APPR.		
DATE	08.07.16	

92464



D2750-041 350 SKIDTUBE ASSEMBLY, LH

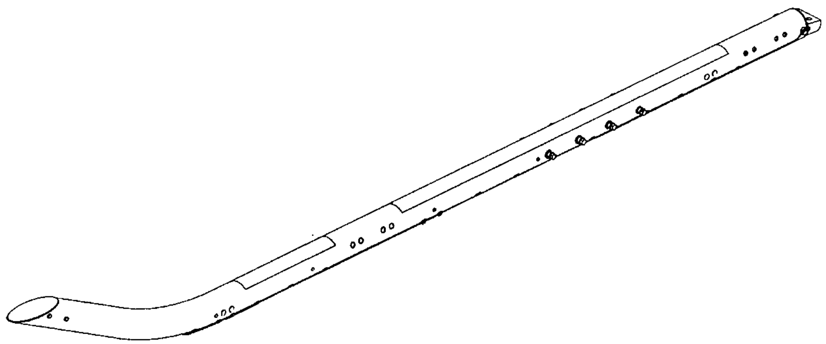


D2750-042 350 SKIDTUBE ASSEMBLY, RH

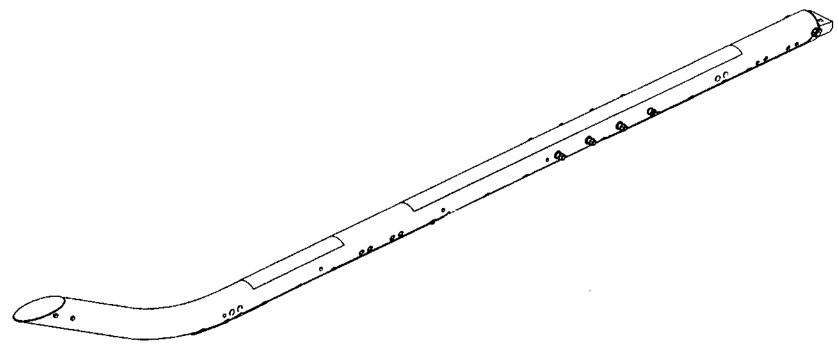
RELEASED

DESIGN	PC	**DART AEROSPACE USA, INC.** PORT HADLOCK, WA
DRAWN	PC	DRAWING NO. D2750 — REV. F — SHEET 2 OF 11
CHECKED		
MFG. APPR.		TITLE 350 SKIDTUBE ASSEMBLY — SCALE NTS
APPROVED		
DE APPR.		
DATE	08.07.16	

92464



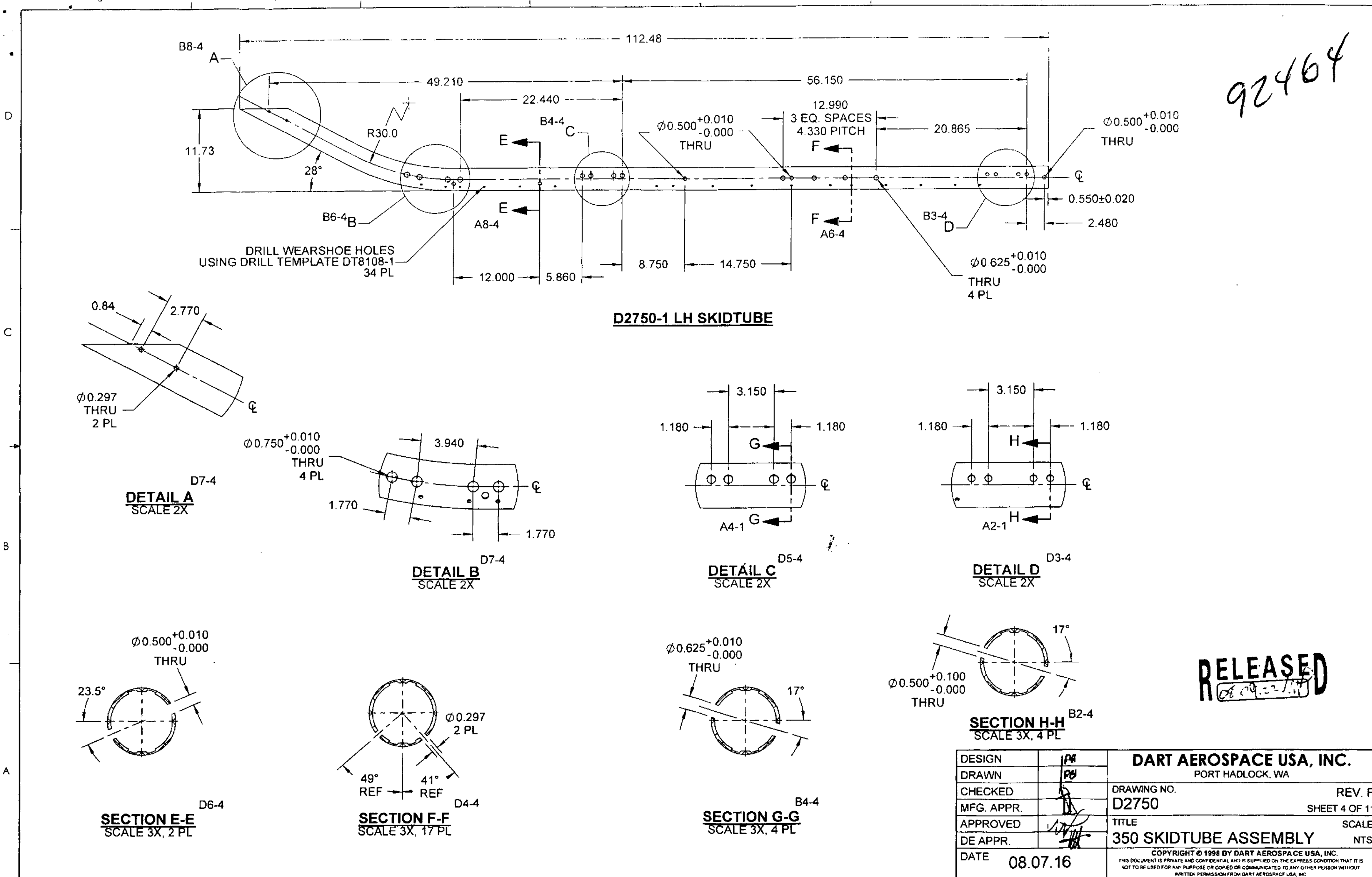
D2750-043 350 SKIDTUBE ASSEMBLY, LH



D2750-044 350 SKIDTUBE ASSEMBLY, RH

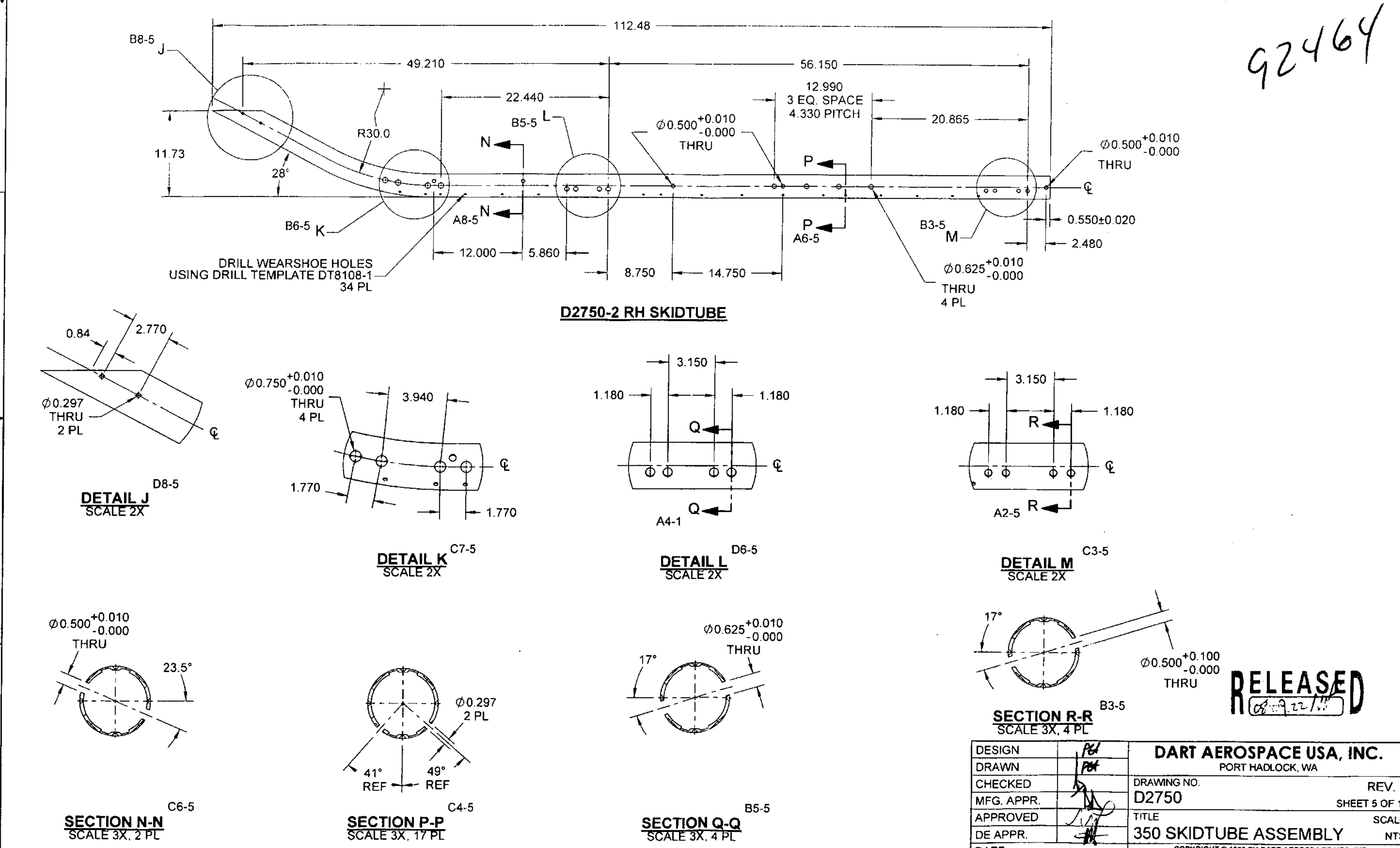
RELEASED 08.09.22

DESIGN		DART AEROSPACE USA, INC. PORT HADLOCK, WA
DRAWN		DRAWING NO. D2750 — REV. F — SHEET 3 OF 11
CHECKED		
MFG. APPR.		TITLE 350 SKIDTUBE ASSEMBLY — SCALE NTS
APPROVED		
DE APPR.		
DATE	08.07.16	



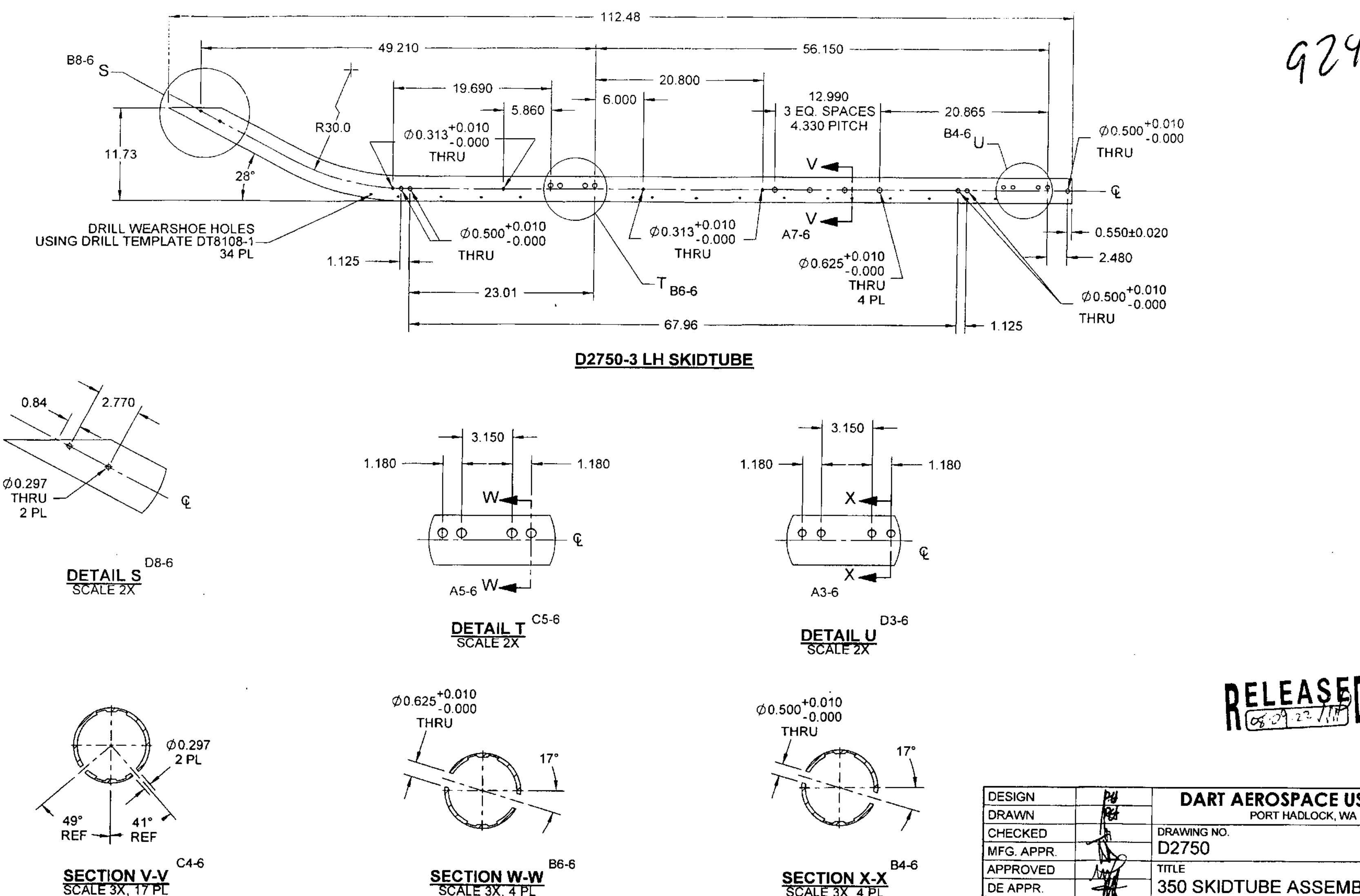
92464
112.48
49.210
56.150
22.440
12.990
3 EQ. SPACES
4.330 PITCH
20.865
B8-4
A
B4-4
C
R30.0
11.73
28°
Ø0.500 +0.010 -0.000 THRU
Ø0.500 +0.010 -0.000 THRU
E
F
0.550±0.020
2.480
B6-4 B
A8-4
A6-4
B3-4 D
DRILL WEARSHOE HOLES
USING DRILL TEMPLATE DT8108-1
34 PL
12.000
5.860
8.750
14.750
Ø0.625 +0.010 -0.000 THRU 4 PL
D2750-1 LH SKIDTUBE
0.84
2.770
Ø0.297 THRU 2 PL
D7-4
DETAIL A
SCALE 2X
Ø0.750 +0.010 -0.000 THRU 4 PL
3.940
1.770
1.770
D7-4
DETAIL B
SCALE 2X
3.150
1.180
1.180
G
A4-1
D5-4
DETAIL C
SCALE 2X
3.150
1.180
1.180
H
A2-1
D3-4
DETAIL D
SCALE 2X
Ø0.500 +0.010 -0.000 THRU
23.5°
D6-4
SECTION E-E
SCALE 3X, 2 PL
Ø0.297 2 PL
49° REF
41° REF
D4-4
SECTION F-F
SCALE 3X, 17 PL
Ø0.625 +0.010 -0.000 THRU
17°
B4-4
SECTION G-G
SCALE 3X, 4 PL
17°
Ø0.500 +0.100 -0.000 THRU
B2-4
SECTION H-H
SCALE 3X, 4 PL
RELEASED
DESIGN
DRAWN
CHECKED
MFG. APPR.
APPROVED
DE APPR.
DATE 08.07.16
DART AEROSPACE USA, INC.
PORT HADLOCK, WA
DRAWING NO.
D2750
REV. F
SHEET 4 OF 11
TITLE
350 SKIDTUBE ASSEMBLY
SCALE
NTS
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92464

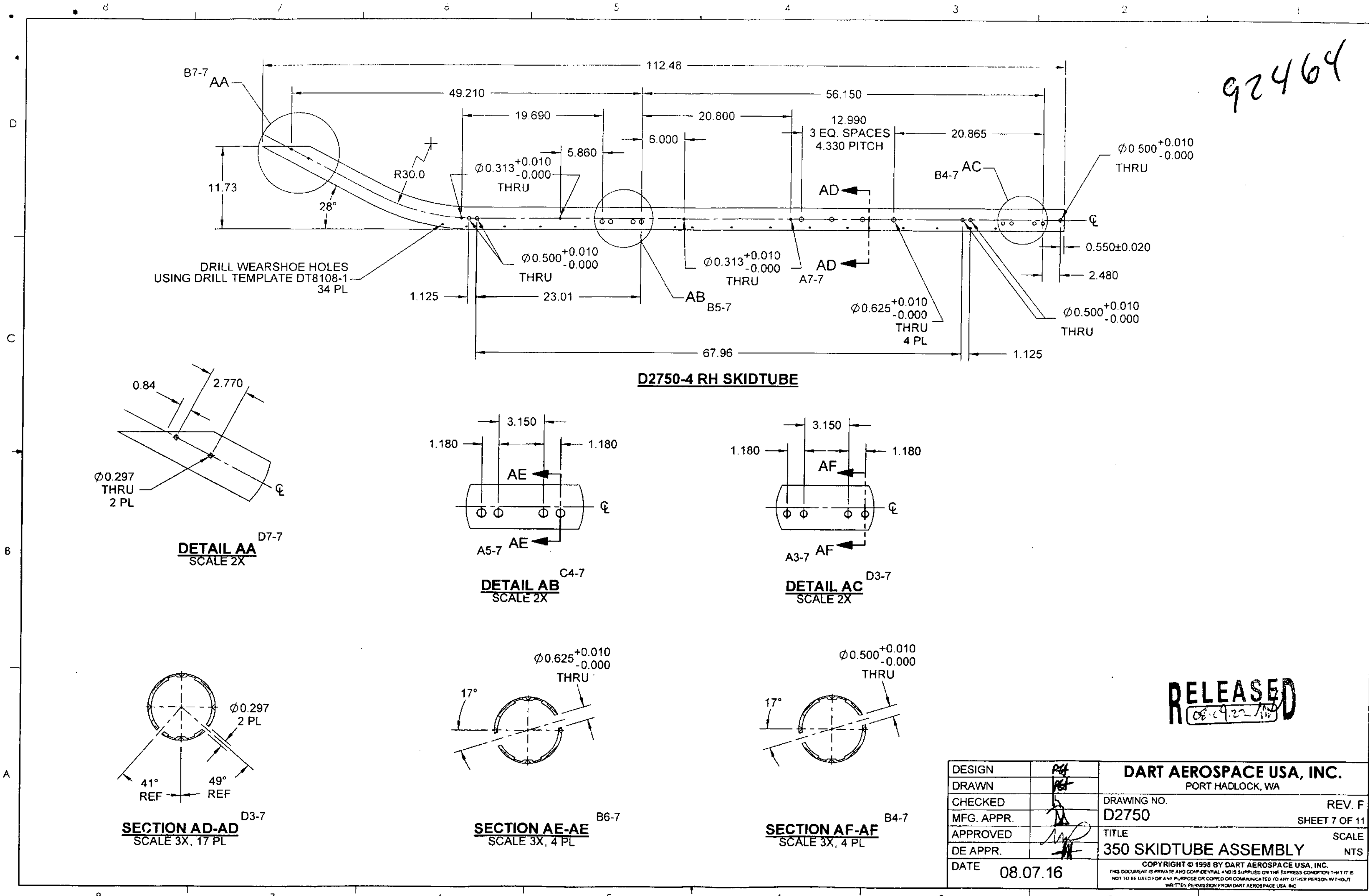


DESIGN	PGI	**DART AEROSPACE USA, INC.** PORT HADLOCK, WA
DRAWN	PGI	DRAWING NO. D2750 — REV. F — SHEET 5 OF 11
CHECKED		
MFG. APPR.		
APPROVED		TITLE: 350 SKIDTUBE ASSEMBLY — SCALE: NTS
DE APPR.		
DATE	08.07.16	

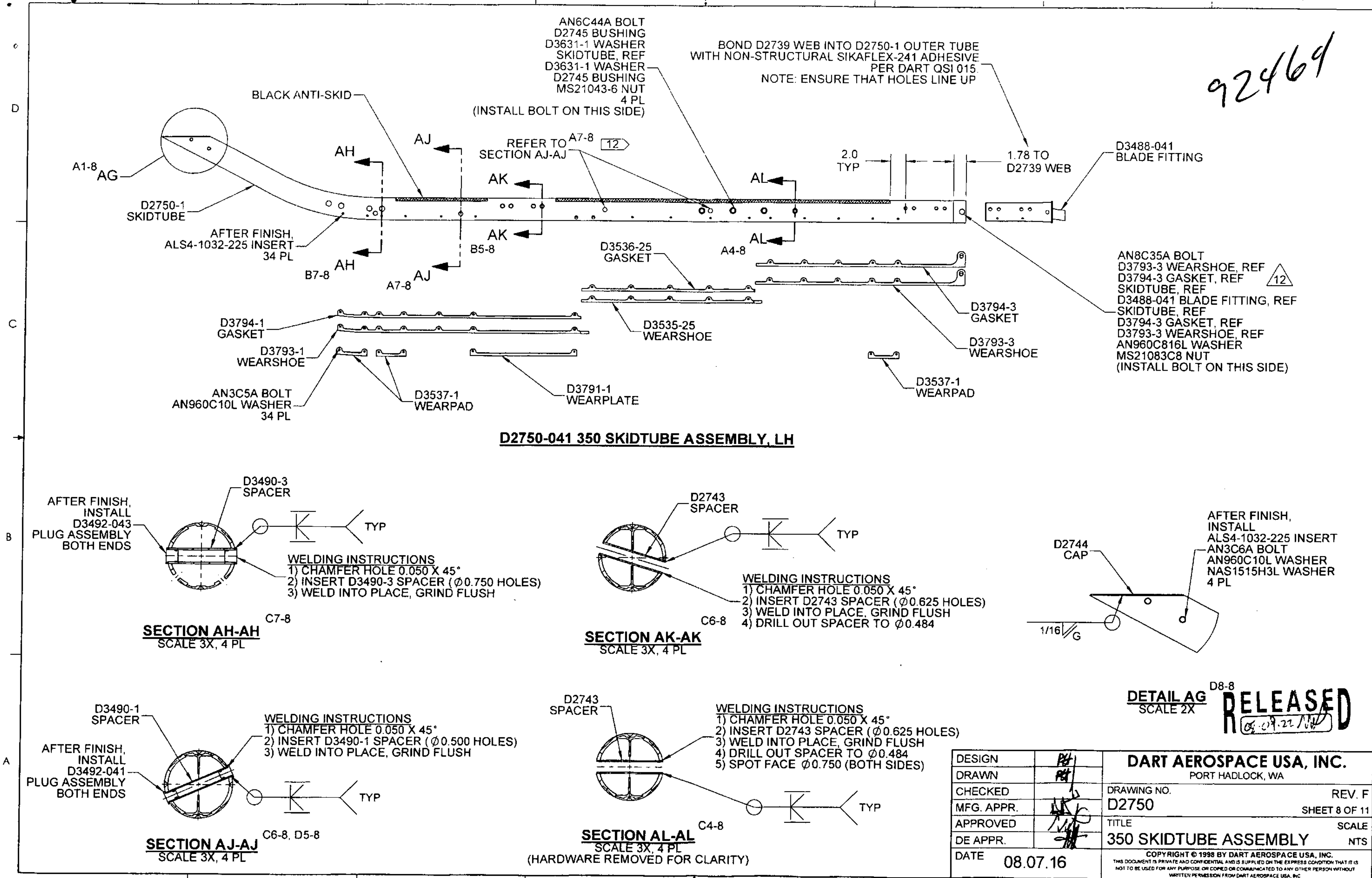
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DESIGN		DART AEROSPACE USA, INC. PORT HADLOCK, WA
DRAWN		DRAWING NO. D2750 — REV. F — SHEET 6 OF 11
CHECKED		
MFG. APPR.		TITLE 350 SKIDTUBE ASSEMBLY — SCALE NTS
APPROVED		
DE APPR.		
DATE	08.07.16	



DESIGN		DART AEROSPACE USA, INC. PORT HADLOCK, WA
DRAWN		DRAWING NO. D2750 — REV. F — SHEET 7 OF 11
CHECKED		
MFG. APPR.		TITLE 350 SKIDTUBE ASSEMBLY — SCALE NTS
APPROVED		
DE APPR.		
DATE	08.07.16	



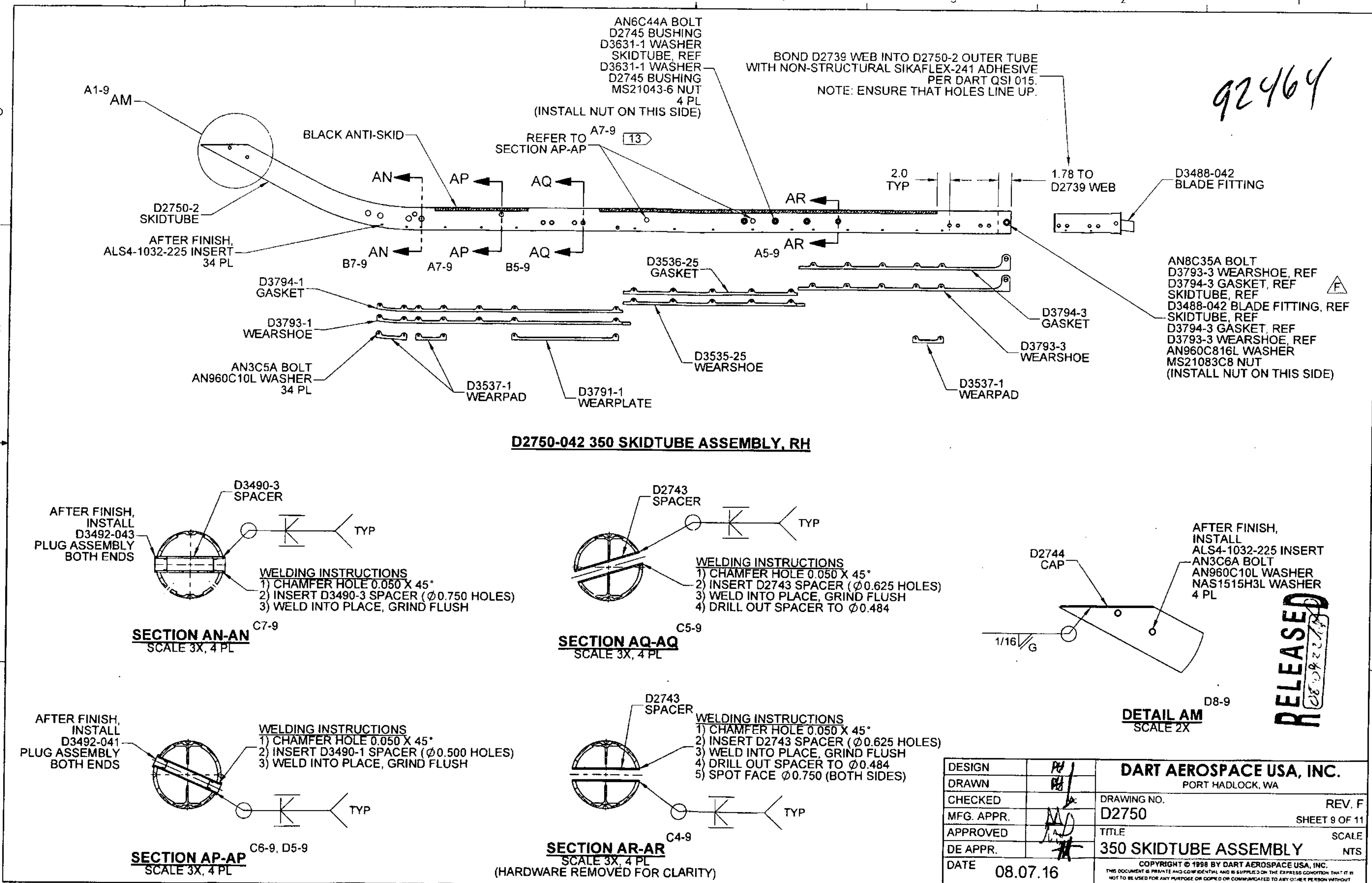
DESIGN | DRAWN | CHECKED | MFG. APPR. | APPROVED | DE APPR.

DATE 08.07.16

DART AEROSPACE USA, INC.
PORT HADLOCK, WA

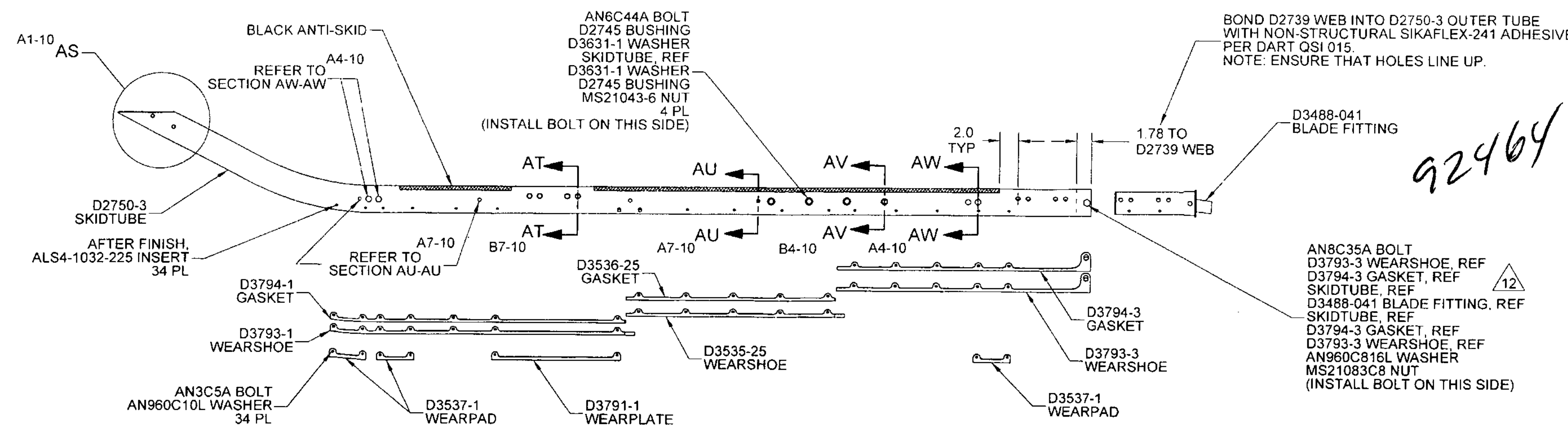
DRAWING NO. D2750 REV. F SHEET 8 OF 11

TITLE 350 SKIDTUBE ASSEMBLY SCALE NTS

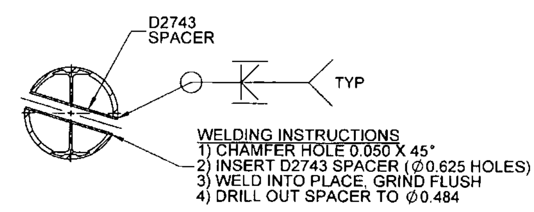


DESIGN		DART AEROSPACE USA, INC. PORT HADLOCK, WA
DRAWN		DRAWING NO. D2750 — REV. F — SHEET 9 OF 11
CHECKED		
MFG. APPR.		
APPROVED		TITLE 350 SKIDTUBE ASSEMBLY — SCALE NTS
DE APPR.		
DATE	08.07.16	

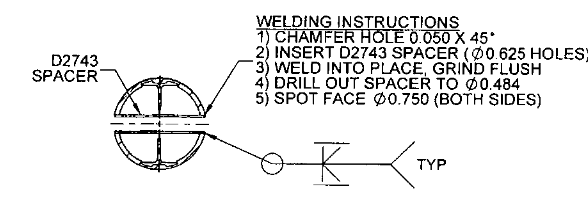
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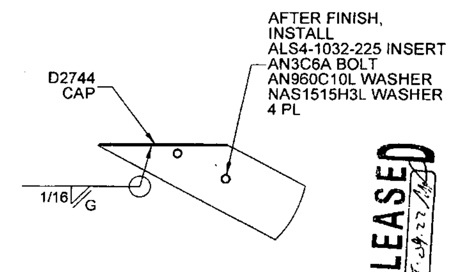
D2750-043 350 SKIDTUBE ASSEMBLY, LH



SECTION AT-AT D6-10
SCALE 3X, 4 PL

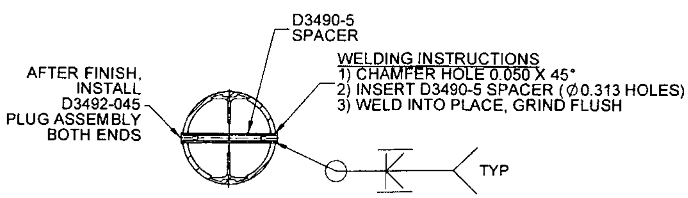


SECTION AV-AV D4-10
SCALE 3X, 4 PL
(HARDWARE REMOVED FOR CLARITY)

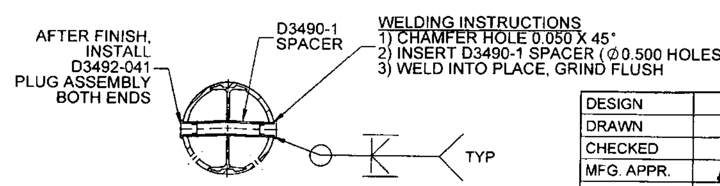


DETAIL AS D8-10
SCALE 2X

RELEASED

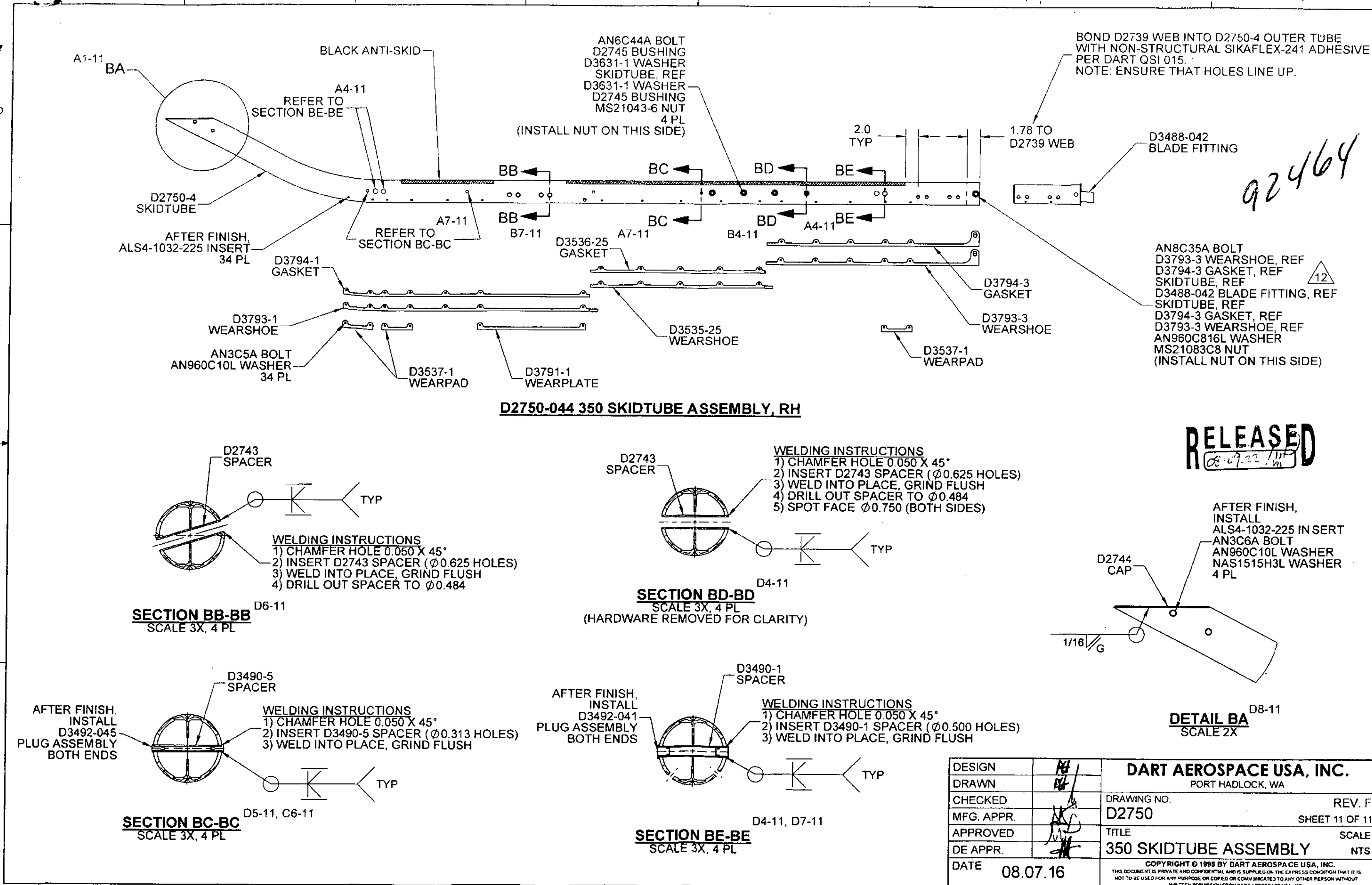


SECTION AU-AU D5-10, D6-10
SCALE 3X, 4 PL



SECTION AW-AW D4-10, D7-10
SCALE 3X, 4 PL

DESIGN		**DART AEROSPACE USA, INC.** PORT HADLOCK, WA
DRAWN		
CHECKED		DRAWING NO. D2750 — REV. F — SHEET 10 OF 11
MFG. APPR.		
APPROVED		TITLE 350 SKIDTUBE ASSEMBLY — SCALE NTS
DE APPR.		
DATE	08.07.16	



BLACK ANTI-SKID
A1-11 BA
A4-11 REFER TO SECTION BE-BE
AN6C44A BOLT
D2745 BUSHING
D3631-1 WASHER
SKIDTUBE, REF
D3631-1 WASHER
D2745 BUSHING
MS21043-6 NUT
4 PL
(INSTALL NUT ON THIS SIDE)
BOND D2739 WEB INTO D2750-4 OUTER TUBE WITH NON-STRUCTURAL SIKAFLEX-241 ADHESIVE PER DART QSI 015.
NOTE: ENSURE THAT HOLES LINE UP.
2.0 TYP
1.78 TO D2739 WEB
D3488-042 BLADE FITTING
D2750-4 SKIDTUBE
AFTER FINISH, ALS4-1032-225 INSERT 34 PL
A7-11 REFER TO SECTION BC-BC
B7-11
A7-11
B4-11
A4-11
D3536-25 GASKET
D3794-1 GASKET
D3794-3 GASKET
D3793-1 WEARSHOE
D3793-3 WEARSHOE
D3535-25 WEARSHOE
AN3C5A BOLT
AN960C10L WASHER
34 PL
D3537-1 WEARPAD
D3791-1 WEARPLATE
D3537-1 WEARPAD
AN8C35A BOLT
D3793-3 WEARSHOE, REF
D3794-3 GASKET, REF
SKIDTUBE, REF
D3488-042 BLADE FITTING, REF
SKIDTUBE, REF
D3794-3 GASKET, REF
D3793-3 WEARSHOE, REF
AN960C816L WASHER
MS21083C8 NUT
(INSTALL NUT ON THIS SIDE)
12
D2750-044 350 SKIDTUBE ASSEMBLY, RH
RELEASED
92464
D2743 SPACER
TYP
WELDING INSTRUCTIONS
1) CHAMFER HOLE 0.050 X 45°
2) INSERT D2743 SPACER (Ø0.625 HOLES)
3) WELD INTO PLACE, GRIND FLUSH
4) DRILL OUT SPACER TO Ø0.484
SECTION BB-BB D6-11
SCALE 3X, 4 PL
D2743 SPACER
WELDING INSTRUCTIONS
1) CHAMFER HOLE 0.050 X 45°
2) INSERT D2743 SPACER (Ø0.625 HOLES)
3) WELD INTO PLACE, GRIND FLUSH
4) DRILL OUT SPACER TO Ø0.484
5) SPOT FACE Ø0.750 (BOTH SIDES)
TYP
SECTION BD-BD D4-11
SCALE 3X, 4 PL
(HARDWARE REMOVED FOR CLARITY)
AFTER FINISH, INSTALL
ALS4-1032-225 INSERT
AN3C6A BOLT
AN960C10L WASHER
NAS1515H3L WASHER
4 PL
D2744 CAP
1/16
DETAIL BA D8-11
SCALE 2X
D3490-5 SPACER
AFTER FINISH, INSTALL D3492-045 PLUG ASSEMBLY BOTH ENDS
WELDING INSTRUCTIONS
1) CHAMFER HOLE 0.050 X 45°
2) INSERT D3490-5 SPACER (Ø0.313 HOLES)
3) WELD INTO PLACE, GRIND FLUSH
TYP
SECTION BC-BC D5-11, C6-11
SCALE 3X, 4 PL
D3490-1 SPACER
AFTER FINISH, INSTALL D3492-041 PLUG ASSEMBLY BOTH ENDS
WELDING INSTRUCTIONS
1) CHAMFER HOLE 0.050 X 45°
2) INSERT D3490-1 SPACER (Ø0.500 HOLES)
3) WELD INTO PLACE, GRIND FLUSH
TYP
SECTION BE-BE D4-11, D7-11
SCALE 3X, 4 PL
DESIGN
DRAWN
CHECKED
MFG. APPR.
APPROVED
DE APPR.
DATE 08.07.16
DART AEROSPACE USA, INC.
PORT HADLOCK, WA
DRAWING NO. D2750
REV. F
SHEET 11 OF 11
TITLE 350 SKIDTUBE ASSEMBLY
SCALE NTS
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5.0 PARTS LIST
(D350-636-011/-012/-013/-014 SKIDTUBES AT CHANGE 003)

Item	Qty -011	Qty -012	Qty -013	Qty -014	Qty -043	Part Number	Description
	X					D350-636-011	SKIDTUBE INSTALLATION, LH, STD AERAZUR/APICAL CYLINDRICAL FLOAT COMPATIBLE
		X				D350-636-012	SKIDTUBE INSTALLATION, RH, STD AERAZUR/APICAL CYLINDRICAL FLOAT COMPATIBLE
			X			D350-636-013	SKIDTUBE INSTALLATION, LH AIRCRUISER/ APICAL TRI-BAG FLOAT COMPATIBLE
				X		D350-636-014	SKIDTUBE INSTALLATION, RH AIRCRUISER/ APICAL TRI-BAG FLOAT COMPATIBLE
					X	D350-636-043	WEARSHOE KIT (REPLACES -041 KIT)
1	1					D2750-041	SKIDTUBE ASSEMBLY, LH
1		1				D2750-042	SKIDTUBE ASSEMBLY, RH
1			1			D2750-043	SKIDTUBE ASSEMBLY, LH
1				1		D2750-044	SKIDTUBE ASSEMBLY, RH
*1	1					D2750-1	SKIDTUBE WELDMENT, LH
*1		1				D2750-2	SKIDTUBE WELDMENT, RH
*1			1			D2750-3	SKIDTUBE WELDMENT, LH
*1				1		D2750-4	SKIDTUBE WELDMENT, RH
**2	8	8	8	8		350A41-1027-20	SCREW
**3	8	8	8	8		23119AG120LE	WASHER
**4	8	8	8	8		22541N120	NUT
*5	1	1	1	1		AN8C35A	BOLT (REPLACES AN8-35A)
*6A	~~2~~	~~2~~	~~2~~	~~2~~		~~AN960C816L~~	~~WASHER (REPLACES AN960JD816)~~
*6B	2	2	2	2		NAS1515H8L	WASHER
*7	~~1~~	~~1~~	~~1~~	~~1~~		~~MS21083C8~~	~~NUT (REPLACES MS21083N8)~~
*8	1		1			D3488-041	BLADE FITTING, LH (REPLACES D2742-1)
*8		1		1		D3488-042	BLADE FITTING, RH (REPLACES D2742-2)
9	~~1~~	~~1~~	~~1~~	~~1~~		~~D2741~~	~~BLADE~~
10	~~2~~	~~2~~	~~2~~	~~2~~		~~AN8C21A~~	~~BOLT (REPLACES AN8-16A)~~
11A	~~2~~	~~2~~	~~2~~	~~2~~		~~AN960C816L~~	~~WASHER (REPLACES AN960JD816)~~
11B	2	2	2	2		D3672-13	WASHER
12	~~2~~	~~2~~	~~2~~	~~2~~		~~MS21083C8~~	~~NUT (REPLACES MS21083N8)~~
*13	4	4	4	4		ALS4-1032-225	INSERT
*14	4	4	4	4		AN6C44A	BOLT (REPLACES AN6-44A)
*15	8	8	8	8		D2745	BUSHING
*16	4	4	4	4		MS21043-6	NUT (REPLACES MS21042L6)
*17	8	8	8	8		D3631-1	WASHER (REPLACES NAS1515H8L)
*18	4	4	4	4		ALS4-1032-225	INSERT (REPLACES NAS1330S3KB166)
*19	4	4	4	4		AN3C6A	BOLT (REPLACES AN3-6A)

(CONTINUED ON NEXT PAGE)

(CONTINUED FROM PREVIOUS PAGE)

Item	Qty -011	Qty -012	Qty -013	Qty -014	Qty -045	Part Number	Description
*22	3	3	3	3	3	D3537-1	WEARPAD
*22A	1	1	1	1	1	D3791-1	WEARPLATE (REPLACES D3537-1)
*23A	1	1	1	1	1	D3793-1	WEARSHOE (REPLACES D3535-13)
*23B	1	1	1	1	1	D3794-1	GASKET (REPLACES D3536-13)
*24A	1	1	1	1	1	D3535-25	WEARSHOE
*24B	1	1	1	1	1	D3536-25	GASKET
*25A	1	1	1	1	1	D3793-3	WEARSHOE (REPLACES D3535-35)
*25B	1	1	1	1	1	D3794-3	GASKET (REPLACES D3536-35)
*26A	34	34	34	34	34	AN3C5A	BOLT
*27	34	34	34	34	34	AN960C10L	WASHER
*28	34	34	34	34		ALS4-1032-225	INSERT
*30	8	8	8	8		D3492-041	PLUG ASSEMBLY
*31	8	8				D3492-043	PLUG ASSEMBLY
*32			8	8		D3492-045	PLUG ASSEMBLY
***43	~~2~~	~~2~~	2	2		~~D3493-1~~	~~WASHER~~
50	~~2~~	~~2~~				~~D3532-1~~	~~SPACER~~

* PART OF D2750-041/-042 OR D2750-043/-044 ASSEMBLY
** TO BE SUPPLIED BY CUSTOMER
*** ONLY INSTALLED IF INSTALLING AN APICAL FLOAT SYSTEM